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LARGE AIRCRAFT COATINGS FLIGHT TESTING



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EXECUTIVE SUMMARY

The advent of the National Emission Standard for Hazardous Air Pollutants (NESHAP) and the concomitant requirements for minimal release of hazardous air pollutants have compelled the U.S. Air Force to adopt the use of paints with reduced Volatile Organic Compounds (VOCs). Self Priming Topcoat, TT-P-2756, formerly used on the exterior of the KC-135s was not performing satisfactorily with regards to adhesion, corrosion resistance, weatherability, and cleanability.

The High Performance Aerospace Coating System (HPACS) project conducted by Battelle identified four paint systems which offer improved film properties: System 23 from US Paint, System 6 from PRC-DeSoto (Courtaulds Aerospace), System 14 from Spraylat, and System 3 from Sherwin-Williams. The objective of this study was to monitor the performance of these improved systems when applied to aircraft. The Deft system from GSA, MIL-P-23377G and MIL-PRF-85285C, was used as a control. APC, urethane fluoropolymer topcoat from Deft, and applique were added to the monitoring.

Two KC-135s were painted at OC-ALC. One was coated with a system from US Paints and is based at MacDill AFB, FL; the other one had the upper surface of the left wing coated with APC (urethane fluoropolymer topcoat from Deft). Applique was applied over topcoat to areas of the right wing and a portion of the fuselage of this KC-135. It is assigned to Kadena AB, Japan. Two KC-135s were divided in the middle of the fuselage and refinished with different paint systems on each side at SM-ALC. One aircraft was coated with paint systems from Deft and PRC-DeSoto (Courtaulds); the other KC-135 was coated with paint systems from Spraylat and Sherwin-Williams. These aircraft are based at Hickam AFB, HI.

The latest inspection of the MacDill AFB test aircraft was accomplished in February, 1999. This KC-135 had logged 737.2 flight hours and 21 months environmental exposure since being painted. The aircraft had recorded 408.9 flight hours and 12 months Florida exposure between the initial and latest inspection. Visually, little corrosion and paint defects were noted. Considering the months of exposure, it is considered performing the best, although it exhibited fading and moderate chalking.

The latest inspection of the KC-135s at Hickam AFB, HI, shows the Sherwin-Williams (10 months, 328.7 flight hours) coating system to possess the best appearance, visually, followed by Deft (17 months, 612.9 flight hours), Spraylat (10 months, 328.7 flight hours), and PRC-DeSoto (Courtaulds) (17 months, 612.9 flight hours). The PRC-DeSoto (Courtaulds) system has exhibited unacceptable chalking.

The APC system (8 months) has the best appearance, but the least amount of exposure.

Preliminary data show the US Paints system to exhibit improved weatherability over the Deft control judged by the gloss and color stability as well as appearance. Limited exposure data shows Sherwin-Williams to possess improved appearance over the Deft control, but experience has shown exposure of 18 to 24 months is required to differentiate between coating systems.

Continued monitoring of these paint systems is recommended.

1.0 PROJECT DESCRIPTION

The objective of this task was to monitor the flight testing of coating systems identified by the High Performance Aerospace Coating System (HPACS) project conducted by Battelle to offer improved film properties of weatherability and cleanability. GSA coating system served as a control. APC (Advanced Performance Coating) and applique have also been included.

2.0 INTRODUCTION

The reason for this project is to field-test coating systems that "exceed" current Mil-Spec coating systems. All tested coatings comply with the 1998 National Emissions Standard for Hazardous Air Pollutants (NESHAP). This project will provide a tool for ALCs to implement the best performing commercial "off the shelf" (COTS) coating system available, utilizing the results of these flights tests.

3.0 BACKGROUND

TT-P-2756, Polyurethane Coating: Self Priming Topcoat coating system used formerly on the exterior moldline of the KC-135 aircraft was not meeting performance requirements over the full Programmed Depot Maintenance (PDM) cycle. The coating exhibits fading, chalking, and lack of corrosion protection.

The laboratory test and evaluation for a NESHAP compliant system with improved performance was accomplished via the HPACS contractual program managed by AFRL/MLSS. Four promising coating systems were identified by the HPACS program as being worthy for flight test consideration. The Deft coating system on the GSA contract was included to serve as a control because of its extensive use on other weapon systems. APC, a urethane fluoropolymer topcoat from Deft, was utilized on the wing of a test aircraft. Patches of paintless film (applique) from 3M was applied to portions of this test aircraft over topcoat to test the barrier properties of applique for corrosion protection. CTIO gathered other data on applique because of the opportunity. This technology is far from being implemented. The test coating systems (primer and topcoat) are tabulated below:

Table 1

Vendor	HPACS	Epoxy Primer	Polyurethane Topcoat
Deft	GSA*	02-Y-40	03-GY-321
PRC-DeSoto (Courtaulds)	System 6**	513X423C/530K015/ 930K118	832G062/930G052
Sherwin-Williams	System 3	E90G203/V93V230	F93A27/V93V26/V93V1
Spraylat	System 14	EEAE 145A/B	EUBC 105B
US Paints	System 23	S9800/K8032	Awlgrip H.S.
Deft	APC (Advanced Performance Coating)	02-Y-40	99-GY-1
3M	Applique	02-Y-40	03-GY-321 + Applique

^{*}Deft reformulated their MIL-P-85285 topcoat in May, 1996 to give better performance

^{**}PRC-DeSoto (Courtaulds) has added UV absorbers to their previous version topcoat to give better performance.

4.0 TECHNICAL APPROACH

The coating systems were tested as drop-in replacements for MIL-P-23377G + TT-P-2756 for use on the outer moldline of KC-135 aircraft. Self Priming Topcoat (SPT) was tried and failed as a unicoat, therefore Tinker AFB and McClellan AFB started using primer (MIL-P-23377G) on selected areas of the aircraft under the SPT.

Operational test sites were selected which represent environments that are severely corrosive, marine, and receive high UV radiation. Two test aircraft were provided by Air Mobility Command (AMC); one is stationed at MacDill AFB, FL, and the other at Kadena AB, Japan. Two test aircraft were provided by Air National Guard (ANG) and are based at Hickam AFB, HI. These bases are designated as severe corrosive environments in T.O. 1-1-691, requiring a clear water rinse after the last flight of the day and a wash every 30 days for aircraft stationed at these locations. The AMC aircraft were coated at Tinker AFB, OK (OC-ALC) and the ANG aircraft were painted at McClellan AFB, CA (SM-ALC).

Testing was conducted as outlined in the Operational Test Plan dated August 1997, during the inspections by the CTIO team. The tests included:

TEST	REFERENCE	LOCATIONS
PATTI adhesion (modified)	ASTM D 5179	5-10 per coating system*
Pencil Hardness	ASTM D 3363	5-10 per coating system*
Wet Tape Adhesion	FTMS 141, Method 6301	5 per coating system*
Chalking (modified)	ASTM D 4214, Test Method C	5 per coating system**
Dry Film Thickness		≅ 45 per aircraft***
Gloss, 60° and 85°	ASTM D 523	≅ 45 per aircraft***
CIELab Color (10° observer, D65 illuminant, specular exclusive)	ASTM D 2244	≅ 45 per aircraft***

Table 2

The test plan identified three Critical Operational Issues (COIs) with attendant Measures of Effectiveness (MOE) and Measures of Performance (MOP).

The first Critical Operational Issue (COI) questions if the test coating provides equal or improved corrosion protection compared with the control coating system. In order to ensure the test coating systems show corrosion protection characteristics, the test coating systems shall be flight tested on test aircraft stationed in a severely corrosive, high UV marine environment for a minimum of 20 months. The test coating systems shall show equal or improved performance as compared to the Mil-Spec qualified Deft coating system in order to pass this COI. The Deft coating system will be used as the control coating system.

^{*}Test locations, as indicated in the Aerospace Coating Service Test Technical Evaluation Team Inspection Sheet, Appendix VIII, assess fluid resistance on the belly; locations on the wings determine UV degradation. Subsequent values obtained during later inspections were from nearby locations.

^{**}Test locations on wing, as noted in Appendix VIII, measure UV degradation.

^{***}Test locations, as mapped in Appendix VIII, were chosen to represent different sections of the aircraft, the wings and fuselage. The locations are numbered to enable subsequent values obtained during later inspections to be near the same area.

The Measures of Effectiveness (MOE) are a comparison of the test coating with the control coating for corrosion protection, film integrity around fasteners, and adhesion of coating system.

The Measures of Performance (MOP) are visual inspection for corrosion and film integrity and adhesion values from the wet tape test and modified PATTI Test.

The second COI questions if the test coating offers equal or superior film performance compared with the control coating system. Per MIL-C-85285B, the specular gloss of camouflage topcoats at 60° angle of incidence shall have a reading of 5 or less. MIL-C-85285B topcoats have not been able to maintain the 5 or less reading over time and after many wash cycles. The test coating systems shall show improved performance in maintaining camouflage gloss measured at 60° and 85° over the control coating system in order to pass this COI.

The MOE includes evaluating gloss stability, cleanability and fluid resistance. The MOP uses the gloss meter and color spectrophotometer values to determine depth of change objectively and pencil hardness test to evaluate fluid resistance.

The third COI questions the appearance of the coating system compared with the control coating system. Appearance characteristics are comprised of cleanability of the coating system, color, and gloss stability of the coating system over time and after touch-up and repair, and lastly fluid resistance of the coating system. The test coating systems shall show improved performance in these areas over the control coating system in order to pass this COI.

The MOE includes evaluating the cleanability, gloss and color stability, fluid resistance and color/gloss matching of repaired areas. The MOP uses the gloss meter and color spectrophotometer values to assign numerical values relating to visual differences and pencil hardness test to evaluate fluid resistance.

Flight-testing is on going. Test aircraft are monitored at approximately 6-month intervals.

5.0 TEST OBSERVATIONS

The coating application and inspections of the test aircraft are tabulated in Table 3. The values of each test and calculations of differences between the initial and subsequent tests are tabulated. Details of the laboratory test results are attached in:

Appendix I	Deft	Control
Appendix II	PRC-DeSoto (Courtaulds)	System 6
Appendix III	Sherwin-Williams	System 3
Appendix IV	Spraylat	System 14
Appendix V	US Paints	System 23
Appendix VI	Deft	APC

KC-135 Summary of Paint Application and Inspection

MacDill AFB, FL AMC 1999 Hickam AFB, HI 999 ANG Hickam AFB, HI	il AFB, FL m AFB, HI m AFB, HI	MacDill AFB, FL AMC 1999 Hickam AFB, HI ANG ANG	OC-ALC Jan., 1998 MacDill AFB, FL July, 1998 AMC February, 1999 SM-ALC July, 1998 Hickam AFB, HI January, 1999 ANG SM-ALC July, 1998 Hickam AFB, HI	y 97 OC-ALC Jan. , 1998 MacDill AFB, FL July, 1998 AMC February, 1999 Hickam AFB, HI Sept. 1997 SM-ALC July, 1998 ANG January, 1999 ANG March SM-ALC July, 1998 Hickam AFB, HI	5 May 97 OC-ALC Jan., 1998 MacDill AFB, FL July, 1998 AMC February, 1999 Hickam AFB, HI January, 1999 ANG	OC-ALC Jan., 1998 MacDill AFB, FL July, 1998 AMC February, 1999 SM-ALC July, 1998 Hickam AFB, HI January, 1999 ANG
Hickam AFB, HI ANG Hickam AFB, HI	Hickam AFB, HI ANG Hickam AFB, HI	July, 1998 Hickam AFB, HI January, 1999 ANG July, 1998 Hickam AFB, HI ANG	SM-ALC July, 1998 Hickam AFB, HI January, 1999 ANG SM-ALC July, 1998 Hickam AFB, HI	SM-ALC July, 1998 Hickam AFB, HI January, 1999 ANG SM-ALC July, 1998 Hickam AFB, HI	23-26 Sept. 1997 SM-ALC July, 1998 Hickam AFB, HI January, 1999 ANG	23-26 Sept. 1997 SM-ALC July, 1998 Hickam AFB, HI January, 1999 ANG
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	Janua		OC-ALC	OC-ALC	1998 1998 7 29 May 1998 OC-ALC	1998 1998 7 29 May 1998 OC-ALC

Table 3

5.1 Deft (Control) was first inspected at 10 months and 323.8 flight hours. It exhibited no chalking. The aircraft was undergoing isochronal inspection; therefore it had been washed and was in the hangar.

Witness panels had been placed on the aircraft at locations stated in Appendix I during paint application. "Initial values" had been obtained from these panels. Only small color changes were noted, showing a slightly lighter color on the wing and a slightly darker color on the fuselage. The delta L* on the wing was 0.3 and negative 1.0 on the fuselage resulting in a delta E* of 1.0 on both the wing and fuselage. The 60° gloss value was lower on the wing and slightly higher on the fuselage resulting in a reduced 60° gloss reading average (0.4) for the aircraft. The 85° gloss value was higher for both the wing and the fuselage, averaging 1.0 increase for the aircraft.

The modified PATTI values averaged 1764 psi on the belly and were very consistent. Modified PATTI values on the wing ranged from 1225 to 1862 psi averaging 1544 psi.

Corrosion was noted around fasteners, on the wing trailing edge, and on the doors of the front landing gear. Paint peeling was noted fasteners, engine cowling, and the leading edge.

At 17 months and 612.9 flight hours the color had changed showing the wing to be lighter and the fuselage to be very slightly darker. Comparison with the initial readings gave a delta L* of 3.2 on the wing and negative .3 on the fuselage calculating to a delta E* of 3.2 on the wing and .9 on the fuselage. The 60° gloss was reduced on the wing and increased slightly on the fuselage netting a slight loss of gloss (0.2). The 85° gloss was higher on both the wing and fuselage, average increase for the aircraft was 0.8 units. Chalking was moderate, rating from 5 to 8 per Photographic Reference Standard on ASTM D 659. (The higher the number the less the chalking.)

The modified PATTI test values averaged 1343 psi on the fuselage and 1493 psi on top of the wings. The values were very consistent. More details are listed in Appendix I.

Peeling was noted on the underside and leading edge of the wing, panel edges, on the sealant, and around the windshield. More details are noted in Appendix VII, Comments from Mike Sneed, OC-ALC/CRA.

5.2 PRC-DeSoto (Courtaulds) System was first inspected at 10 months and 323.8 flight hours. The chalking was moderate and rated an 8. The aircraft was undergoing isochronical inspection; therefore it had been washed and was in the hangar.

Witness panels had been placed on the aircraft at locations stated in Appendix II during paint application. Initial values were taken from these panels. Both the wing and the fuselage were lighter in color with a delta L* of 3.4 on the wing and .9 on the fuselage resulting in a delta E* of 3.5 on the wing and 0.9 on the fuselage. The 60° gloss was lowest of all of the test coatings and remained unchanged (1.0). The 85° gloss was slightly higher than the initial values (0.8 increase).

PATTI values for the fuselage ranged from 784 psi to 1470 psi averaging 1176 psi. The top of the wings ranged from 686 psi to 1176 psi averaging 931 psi.

Paint peeling was noted on fasteners on the leading edge and spoilers. Paint loss was noted on the leading edge of the horizontal stabilizer. Corrosion was noted on the trailing edges, fuselage, and doors of the front landing gear.

When inspected at 17 months and 612.9 flight hours, the color was even lighter with a delta L* of 4.7 on the wing and 3.5 for the fuselage resulting in a delta E* of 4.8 on the wing and 3.6 on the fuselage calculated from the initial color values. The 60° and 85° gloss values were slightly higher (60° - 0.4 increase, 85° - 1.1 increase). Chalking was severe, rating a 4.

Values for modified PATTI test ranged from 597 psi to 1343 psi on the fuselage averaging 1028 psi. The top of the wings ranged from 746 psi to 1194 psi averaging 888 psi. More details are explained in Appendix II.

Paint peeling was noted on the underside of the wings, on the Oklahoma Door, and around the Radome. Bare metal was apparent around the windshield and on the leading edge. More details are recorded in Appendix VII, Comments from Mike Sneed, OC-ALC/CRA.

5.3 Sherwin-Williams system was first inspected at 4 months and 145.2 flight hours. The finish exhibited no chalking. It was inspected on the flight line and the last wash was indeterminate. Hickam AFB wash rack was closed and a waiver had been requested.

Initial values that were obtained from the aircraft surface the day after the topcoat was applied utilizing the locations mapped in Appendix VIII were determined to be incorrect due to equipment malfunction. Calculations were made utilizing average readings for Fed. Standard 595B 36173. Little change in color was noted. The delta L* on the wing was negative .83 and .45 on the fuselage computing to a delta E* of .84 on the wing and 1.3 on the fuselage. Both the 60° and 85° gloss readings were slightly higher (0.6 unit increase for both 60° and 85° angle of incidence).

Pull values on the belly using the modified PATTI test ranged from 1274 psi to 1813 psi averaging 1519 psi. The top of the wings ranged from 1078 to 1862 psi averaging 1470 psi.

Paint loss was noted around fasteners on the aft end of the filler flap. Corrosion was seen around fasteners on the bottom of the fuselage.

At 10 months and 328.7 flight hours, little additional color change was noted. The aircraft was inspected on the flight line. The delta L* was 1.1 on the wing and negative .45 on the fuselage; the delta E* was 1.9 on the wing and 1.1 on the fuselage as calculated from the assumed initial values. Neither 60° nor 85° gloss values differed significantly from the initial values (60° 0.1 unit loss, 85° 0.1 gain). Chalking was moderate, ranging from 6 to 7.

PATTI pulls on the belly ranged from 697 to 746 psi averaging 713 psi. The top of the wings ranged from 1393 to 1691 psi averaging 1559 psi. More details are available in Appendix III.

Repaired areas include fasteners on upper wing, along fuselage seams, and leading edges. Peeling and cracking was noted on panel rivets, on cowling leading edges, and Beaver Tail. More details are recorded in Appendix VII, Comments from Mike Sneed, OC-ALC/CRA.

5.4 Spraylat system was first inspected at 4 months and 145.2 flight hours. No chalking was noted at that time. It was inspected on the flight line and the last wash was indeterminate. Hickam AFB wash rack was closed and a waiver had been requested.

The initial values obtained from the aircraft after painting were found to be erroneous due to equipment malfunction. Calculations were accomplished utilizing average expected color values for Fed standard 595 36173. Both the wing and the fuselage registered lighter in color with a delta L* of .36 on the wing and .37 on the fuselage. This computed to a delta E* of 1.1 on the wing and 1.4 on the fuselage. Both the 60° and 85° gloss values were slightly higher (60°-1.7 increase, 85°-0.6 increase).

Pull values on the belly utilizing the modified PATTI test ranged from 490 to 1078 psi averaging 865 psi. Values for the top of the wings ranged from 882 to 1421 psi averaging 1152 psi.

Paint peeling with corrosion was noted on fasteners on the wing tip. Paint was chipped below the cargo door.

At 10 months and 328.7 flight hours, little additional color change was recorded. The aircraft was inspected on the flight line. The delta L* was .26 on the wing and negative .19 on the fuselage leading to a delta E* of 1.8 on the wing and 1.2 on the fuselage as calculated from the assumed initial values. 60° gloss had increased 0.4 units from initial values and 85° gloss was unchanged. Chalking was moderate, ranging from 6 to 8.

Modified PATTI values for the belly ranged from 398 to 945 psi, averaging 713 psi. The top of the wings ranged from 796 to 945 psi averaging 879 psi. Greater details are available in Appendix IV.

Rework was observed on the wing, around fasteners, along fuselage seams, on the leading edge and underside of wing. Primer was showing in boom area. Paint was peeling and cracking along rivet rows and around Radome. More details are recorded in Appendix VII, Comments from Mike Sneed, OC-ALC/CRA.

5.5 US Paints system was first inspected at 8 months and 328.3 flight hours. At that time the aircraft had been assigned to McConnell AFB, KS, for six months and MacDill AFB, FL, for 2 months. Since this was the first inspection by CTIO and the aircraft had been stationed at a mild corrosion environment, the first readings were considered "initial readings". When the aircraft was transferred to MacDill AFB, FL, from McConnell AFB KS, blisters were noted on the fuselage above the horizontal stabilizer. When probed, a large (approximately 13 inches by 3 feet) area was discovered to be peeling between the primer and the chromate conversion coating.

The area was repaired. The repair was noticeable at a later date. The aircraft had been washed and was located in a hangar. The magnesium main landing gear follow-up doors exhibited moderate to severe corrosion and were later replaced by aluminum doors. There were a few spots of chipped paint in several areas around sealant and fasteners.

The next inspection 6 months and 168.3 flight hours later showed little change in color with delta L* less than 1 for both the fuselage and the wings. The delta E* was 1.2. The 60° gloss was lower (1.6 unit loss) and the 85° gloss was slightly higher (0.9 units). No chalking was observed.

Modified PATTI values for the belly ranged from 980 to 1274 psi averaging 1094 psi. The top of the wings ranged from 784 to 1421 psi averaging 1103 psi.

Chipped paint was observed on the leading edges of the wings and the horizontal stabilizers, along with the boom attachment points. Other areas include the engine cowlings, under the wing, and above the co-pilot window. Overall comments report most of the coating defects may be due to wear from maintenance, impact chips and broken coating around edges.

The following inspection, one year from the first "initial" inspection, showed a lighter color value with a delta L* 2.6 on the wings and 3.3 on the fuselage calculating to a delta E* of 2.0 on the wings and 2.3 on the fuselage, compared with the "initial" values. The 60° gloss was lower totaling a reduction of 2.8 units. The 85° gloss decreased slightly (0.4 units) from the "initial" values. Chalking was rated moderate, ranging from 6 on top of the wings to 8 under the wings.

Values on the belly for the modified PATTI test ranged from 597 to 1592 psi averaging 1055 psi. The top of the wings ranged from 1940 to 2587 averaging 2279 psi. This aircraft had accumulated a total of 737.2 flight hours since being painted, including 240.6 since the last inspection. Details are tabulated in Appendix V.

Some peeling on the leading edges and around doors and access panels was observed. More details are noted in Appendix VII, Comments from Mike Sneed, OC-ALC/CRA.

5.6 APC from Deft was first inspected at 8 months. The color was slightly darker from when initially painted, with delta L* of negative 1.4 and delta E* of 1.6. The 60° gloss decreased by 0.2 units and the 85° gloss increased by 1.7 units.

Modified PATTI values ranged from 1194 to 1791 psi averaging 1572 psi. Only the top of the wing was coated with APC. Greater detail is offered in Appendix VI.

Corrosion on fasteners was starting. More details are recorded in Appendix VII, Comments from Mike Sneed, OC-ALC/CRA.

5.7 The applique presented a good appearance. When it was removed, no corrosion was observed underneath, but a sticky residue remained that was difficult to dislodge. The gloss value IAW MIL-PRF-85285C was too high (60°= 9.9, 85°=52) initially, but it was not measured on the inspection trip.

5.8 Table 4 tabulates the values observed for gloss (60° and 85°) and CIEL (lightness) color data. The calculated values for delta L* and delta E* are also given for each inspection. The appendix for each coating system gives detailed data including individual dry film thickness readings, CIELab color readings, gloss values, and delta calculations for specific areas on the aircraft. PATTI and wet tape adhesion results, pencil hardness, chalking ratings at specific locations on the aircraft are tabulated.

		Hed		PRCA	(*) The Suit of Section (Section 1998)	PRC. DeScribes of Good and describes and Stranging Stran)	Steerain Williams			Strendie	
	initial	18 mo	Тпо	initial	18 mo	f7 ma	***************************************	4 mo		initial	4.00	18 (00)
L* Total	49.712	49.336	51.145	48.776	50,682	52.576	49.959	49.818	50.182	49.959	49.644	49.947
L* Wing	49.577	49.867	52.896	48.557	52.006	53.257		49.130	51.058		49.598	50.227
L* Fuselage	49.728	48.783	49.705	48.823	49.718	52.280		50.406	49.512		49.585	49.696
∆ L* Totaí		-0.440	1.338		1.996	3.890		-0.141	0.223		-0.315	0.029
∆ L* Wing	•	0.258	3.209		3.449	4.700		-0.829	1.099		-0.361	0.268
Δ L* Fuselage		-1.002	-0.330		0.902	3.464		0.447	-0.447		-0.374	-0.186
Δ E* Total		1.105	2.099		2.142	4.023		1.001	1.399		1.178	1.472
∆ E* Wing		0.912	3.254		3.535	4.763		0.843	1.901		1.101	1.794
∆ E* Fuselage		1.341	0.987		1.089	3.647		1.308	1.078		1.353	1.183
60 degree gloss	2.0	1.6	2.6	6.0	1.0	1.3	12	6 .		1.1	2.8	1.6
85 degree gloss	2.2	3.2	3.3	3.1	3.9	4.2	6.4	4.9	4.3	4.9	4 .	4.3

	Initial	9 mo	13 TO	initial	10 mo	17 mo
L* Total	49.689	50.509	52.822			
L* Wing	49.497	50.420	52.242	50.468	49.053	
L* Fuselage	49.702	50.379	52.653			
∆ L* Total		0.821	3.125			
△L. Wing		0.939	2.629		1.415	
∆ L* Fuselage		0.864	3.316			
∆ E' Total		1.292	2.245			
△ E* Wing		1.243	2.017		1.558	
∆ E* Fuseiage		1.464	2.323			
60 degree gloss	5.0	3.7	2.2	2.5	2.2	
85 degree gloss	6.2	6.9	5.8	2.7	3.9	

Table 4

No gloss readings (60° or 85°) were higher than specified in MIL-PRF-85285C. No wet tape failures occurred. The pencil hardness has increased on the finish from PRC-DeSoto (Courtaulds). The Spraylat system remains the softest of the finishes, but is increasing in hardness. The coating systems from Sherwin-Williams and Deft control present constant pencil hardness. The US Paint system was initially very hard and these values have remained constant. No significant changes have been noted from the modified PATTI test values.

6.0 OPERATIONAL TEST AND EVALUATION TEST PLAN RESPONSE

COI-1: Do the test coating systems provide equal or improved protection against corrosion compared with control coating system?

MOE 1-1: The corrosion protection of the test coating systems shall be equal to or show an improvement over the currently used coating systems.

MOP 1-1-1: Upon visual inspection the test coated skins shall show no more exfoliation corrosion around fastener countersinks and panel edges than on the control coated skins.

Visual inspection observed no more exfoliation corrosion on any of the test aircraft than on the Deft control.

MOP 1-1-2: Upon visual inspection the test coated skins shall show no more filiform corrosion than on the control coated skins.

Visual inspection showed no more filiform corrosion on any of the test aircraft than on the Deft control.

MOE 1-2: The degree of compatibility (adhesion) of primer with the substrate and topcoat with the primer.

MOP 1-2-1: Upon visual inspection the degree of adhesion on the test side shall be equal to or better than the control side for all interfaces.

No more paint loss or peeling was observed on the test coatings than on the Deft control.

MOP 1-2-2: Modified Adhesion PATTI testing per ASTM 5179 shall measure a minimum of 1000 psi.

- Deft control All values were in excess of 1000 psi.
- PRC-DeSoto (Courtaulds) The pull values averaged 1000 psi; some pull values were less.
- Sherwin-Williams Pull values on the wing averaged 1559 psi, but pull values on the belly averaged 700 psi.
- Spraylat Pull values averaged 800 on the aircraft.

- US Paints All values but 2 were in excess of 1000, averaging the values equals over 1600.
- APC all values were over 1000, but only the top of the wing was tested, which normally gives greater values.

MOE 1-3: The integrity of the test coating system on and around upper and lower wing skin fasteners shall be equal or show an improvement over the currently used coating system.

MOP 1-3-1: Upon visual inspection and using the evaluation criteria stated in this test plan the test coating shall score an equal or higher value than the control coating.

Due to time constraints and difficulty to inspect the entire aircraft closely, the detailed rating system was not employed. In general, the integrity of the test coating systems was equal or higher than the control coating.

COI-2: Do the test coating systems provide equal or improved performance in the area of visible detection?

MOE 2-1: The gloss stability of the test coating systems shall be an improvement over the currently used coating systems.

MOP 2-1-1: Use of a portable gloss meter of 60 degree geometry in accordance with ASTM D523 shall show less change in gloss on the test side as compared to the control side.

Deft control showed little gloss change, negative 0.2. Sherwin-Williams – 0.1, Spraylat and PRC-DeSoto (Courtaulds) 0.4, APC – negative 0.2, and US Paints negative 2.3. Only Sherwin-Williams showed less change in gloss and APC exhibited the same change.

MOP 2-1-2: Use of a portable gloss meter of 85 degree geometry in accordance with ASTM D523 shall show less change in gloss on the test side as compared to the control side.

Deft control displayed a change of gloss equal to 0.8 units. PRC-DeSoto (Courtaulds) was higher with 1.1 and APC with 1.7. The other coating systems registered less change in gloss. Sherwin-Williams registered no change.

MOP 2-1-3: Paint chips from the test coating and control coating shall be collected and analyzed in the laboratory to determine physical and chemical properties changes.

CTIO was unable to collect any chips.

MOE 2-2: The cleanability of the test coating systems shall be an improvement over the currently used systems.

MOP 2-2-1: Use of a portable gloss meter of 60 degree geometry in accordance with ASTM D523 shall show less change in gloss on the test side as compared to the control side.

Deft control showed little gloss change, negative 0.2. Sherwin-Williams – 0.1, Spraylat and PRC-DeSoto (Courtaulds) 0.4, APC – negative 0.2, and US Paints negative 2.3. Only Sherwin-Williams showed less change in gloss and APC exhibited the same change.

MOP 2-2-2: Use of a portable gloss meter of 85 degree geometry in accordance with ASTM D523 shall show less change in gloss on the test side as compared to the control side.

Deft control displayed a change of gloss equal to 0.8 units. PRC-DeSoto (Courtaulds) was higher with 1.1 and APC with 1.7. The other coating systems registered less change in gloss. Sherwin-Williams registered no change.

MOP 2-2-3: Paint chips from the test coating and control coating shall be collected and analyzed in the laboratory to determine physical and chemical properties changes.

CTIO was unable to collect any chips.

MOE 2-3: The fluid resistance stability of the test coating systems shall be an improvement over the currently used coating systems.

MOP 2-3-1: Using the pencil hardness technique in accordance with FTMS-141, the change in hardness of the test coating shall be less than the change in hardness on the control coating.

The pencil hardness of the Deft control remained the same between the two inspections. The other test coatings remained the same or increased in hardness except one area of Sherwin-Williams exhibited one pencil hardness unit softer. The APC coating system has only been inspected once. No initial values could be obtained for any coating system.

MOP 2-3-2: Upon visual inspection the degree of adhesion on the test side shall be equal to or better than the control side for all interfaces.

No differences were recorded for adhesion differences as observed between the control coating system and the test coating systems.

MOP 2-3-3: Use of a portable colorimeter in accordance with ASTM D2244 shall show a delta E ratio of test coating system to control coating system of less than 1.0 (i.e. delta E of test coating/delta E of control).

The only calculated ratio less than 1 was APC. The others ranged from 1.1 for US Paints, to 1.9 for Spraylat and PRC-DeSoto (Courtaulds), to 2.1 for Sherwin-Williams.

MOP 2-3-4: Paint chips from the test coating and control coating shall be collected and analyzed in the laboratory to determine physical and chemical properties changes.

CTIO was unable to collect any chips.

COI-3 Do the test coating systems provide equal or improved appearance characteristics over the control coating system?

MOE 3-1: The cleanability of the test coating systems shall be an improvement over the currently used systems.

MOP 3-1-1: Use of a portable gloss meter of 60 degree geometry in accordance with ASTM D523 shall show less change in gloss on the test side as compared to the control side.

Deft control showed little gloss change, negative 0.2. Sherwin-Williams – 0.1, Spraylat and PRC-DeSoto (Courtaulds) 0.4, APC – negative 0.2, and US Paints negative 2.3. Only Sherwin-Williams showed less change in gloss and APC exhibited the same change.

MOP 3-1-2: Use of a portable gloss meter of 85 degree geometry in accordance with ASTM D523 shall show less change in gloss on the test side as compared to the control side.

Deft control displayed a change of gloss equal to 0.8 units. PRC-DeSoto (Courtaulds) was higher with 1.1 and APC with 1.7. The other coating systems registered less change in gloss. Sherwin-Williams registered no change.

MOP 3-1-3: Paint chips from the test coating and control coating shall be collected and analyzed in the laboratory to determine physical and chemical properties changes.

CTIO was unable to collect any chips.

MOE 3-2 The color stability of the test coating shall be an improvement over the currently used coating system.

MOP 3-2-1: Use of a portable gloss meter of 85 degree geometry in accordance with ASTM D523 shall show less change in gloss on the test side as compared to the control side.

Deft control displayed a change of gloss equal to 0.8 units. PRC-DeSoto (Courtaulds) was higher with 1.1 and APC with 1.7. The other coating systems registered less change in gloss. Sherwin-Williams registered no change.

MOP 3-2-2 Use of a black velvet cloth in accordance with ASTM D 4214, Test Method C shall show no evidence of chalking.

The APC exhibited no chalking, but it had endured the least exposure. Deft control was rated 7 as were US Paints and Spraylat. Sherwin-Williams was rated 6 and PRC-DeSoto (Courtaulds) was rated 4. (The coating systems with the higher numbers are rated the most resistance to chalking.)

MOP 3-2-3: Paint chips from the test coating and control coating shall be collected and analyzed in the laboratory to determine physical and chemical properties changes.

CTIO was unable to collect any chips.

MOE 3-3: The gloss stability of the test coating system shall be an improvement over the currently used coating systems.

MOP 3-3-1: Use of a portable gloss meter of 60 degree geometry in accordance with ASTM D523 shall show less change in gloss on the test side as compared to the control side.

Deft control showed little gloss change, negative 0.2. Sherwin-Williams – 0.1, Spraylat and PRC-DeSoto (Courtaulds) 0.4, APC – negative 0.2, and US Paints negative 2.3. Only Sherwin-Williams showed less change in gloss and APC exhibited the same change.

MOP 3-3-2: Use of a portable gloss meter of 85 degree geometry in accordance with ASTM D523 shall show less change in gloss on the test side as compared to the control side.

Deft control displayed a change of gloss equal to 0.8 units. PRC-DeSoto (Courtaulds) was higher with 1.1 and APC with 1.7. The other coating systems registered less change in gloss. Sherwin-Williams registered no change.

MOP 3-3-3: Paint chips from the test coating and control coating shall be collected and analyzed in the laboratory to determine physical and chemical properties changes.

CTIO was unable to collect any chips.

MOE 3-4: The fluid resistance of the test coating systems shall be an improvement over the currently used coating systems

MOP 3-4-1: Using the pencil hardness technique in accordance with FTMS-141, the change in hardness of the test coating shall be less than the change in hardness on the control coating.

The pencil hardness of the Deft control remained the same between the two inspections. The other test coatings remained the same or increased in hardness except one area of Sherwin-Williams exhibited one pencil hardness unit softer. The APC coating system has only been inspected once. No initial values could be obtained for any coating system.

MOP 3-4-2: Upon visual inspection the degree of adhesion on the test side shall be equal to or better than the control side for all interfaces.

No more paint loss or peeling was observed on the test coatings than on the Deft control.

MOP 3-4-3: Use of a portable colorimeter in accordance with ASTM D2244 shall show a delta E ratio of test coating system to control coating system of less than 1.0 (i.e. delta E of test coating/delta E of control).

The only calculated ratio less than 1 was APC. The others ranged from 1.1 for US Paints, to 1.9 for Spraylat and PRC-DeSoto (Courtaulds), to 2.1 for Sherwin-Williams.

MOP 3-4-4. Paint chips from the test coating and control coating shall be collected and analyzed in the laboratory to determine physical and chemical properties changes.

CTIO was unable to collect any chips.

MOE 3-5: The The touch-up/repaired area shall an improvement relative to color and gloss over the currently used coating system.

MOP 3-5-1: Use of a portable colorimeter in accordance with ASTM D2244 shall show a delta E ratio of test coating system to control coating system of less than 1.0 (i.e. delta E of test coating/delta E of control).

CTIO was unable to obtain color readings of repaired areas and calculate values.

MOP 3-5-2: Use of a portable gloss meter of 60 degree geometry in accordance with ASTM D523 shall show less change in gloss on the test side as compared to the control side.

CTIO was unable to obtain gloss readings of repaired areas and calculate values.

MOP 3-5-3: Use of a portable gloss meter of 85 degree geometry in accordance with ASTM D523 shall show less change in gloss on the test side as compared to the control side.

CTIO was unable to obtain gloss readings of repaired areas and calculate values.

MOP 3-5-4: Paint chips from the test coating and control coating shall be collected and analyzed in the laboratory to determine physical and chemical properties changes.

CTIO was unable to collect any chips.

7.0 TEST SUMMARY

The appearance and values of the APC are excellent at this time, but it has less environmental exposure. There is no chalking and the PATTI adhesion tests are excellent. The US Paint system and Deft control exhibited similar values after the same exposure time.

The US Paint system has exhibited good exposure resistance. The aircraft has been painted for 20 months. The values obtained a year apart have shown moderate fading and little loss of 60° gloss. The aircraft had undergone 8 months exposure before inspections were initiated, but this was in a "mild corrosive environment."

Comparing all of the coating systems, they all possessed a better appearance than the other KC-135s that had been painted with TT-P-2756, Self-Priming Topcoat, at the respective bases. At this time, the APC looks excellent, but it does not have as much exposure as the other aircraft. Experience confirms that it takes 18 to 24 months exposure to obtain meaningful data to judge weathering resistance. The US Paints system was painted first and has accumulated 21 months exposure. It has exhibited moderate weatherability.

Visual observations of the KC-135s at Hickam AFB, HI, have ranked Sherwin-Williams to have the best appearance, followed by Deft control, Spraylat and PRC-DeSoto (Courtaulds). The PRC-DeSoto (Courtaulds) system has displayed unacceptable chalking.

All observed corrosion has been around fastener heads and rivets. This probably indicates the general need for a more flexible primer for larger aircraft like the KC-135. Corrosion under antennae was evident, but not coating system related.

8.0 COMPARISON OF LABORATORY DATA WITH FLIGHT DATA

Laboratory testing was accomplished by Battelle for the HPACS Program for AFRL/MLSS. Table 5 summarizes data from Page 27 of the RELIABILITY AND MAINTAINABILITY IMPROVEMENT, HIGH PERFORMANCE AEROSPACE COATING SYSTEM PROGRAM. Final Report. The final overall composite desirability index conducted ranks the test coating systems in the following manner:

Table 5

Category	System 3	System 6	System 14	System 23	System 26	System 17
	Sherwin- Williams	PRC-DeSoto (Courtaulds)	Spraylat	US Paints	Deft control	Defi TT-P- 2756 (SPT)
Survivability	.05	.01	.17	.05	.05	.03
Corrosion	.88	.93	.97	1.0	1.0	.20
Appearance	.65	.76	.59	.78	.57	.75
General	,63	.50	.56	.45	.43	.63
Flow Time	.63	.79	.79	.72	.79	.70
Composite	.59	.60	.59	.66	.53	.54

The larger number represents greater desirability.

All of the test systems were rated high for corrosion resistance as tested, utilizing Salt Fog, Filiform, and EIS (Electrochemical Impedance Spectroscopy).

Artificial weathering data is summarized from this report, Appendix H.

Table 6 compares the laboratory test data for artificial weathering of the four systems judged to be worthy of flight testing, the GSA control and SPT (TT-P-2756):

Table 6

Test		System 4	System 6	System 14	System 23	System 26	System 17
		Sherwin- Williams	PRC-DeSoto (Courtaulds)	Spraylat	US Paints	Deft control	Deft TT-P- 2756 (SPT)
Xenon Arc	ΔL*	0.2	2.1	-0.2	0.6	0.2	1.6
Weather-	ΔΕ*	0.3	2.0	0.3	0.6	0.2	1.6
ometer -	Δ60°	-0.4	-0.8	0.0	+0.3	+0.1	-1.6
1000 hours	Δ85°	+1.0	-0.3	+0.3	+1.3	+0.3	+3.2
QUV –	ΔL*	0.8	1.5	0.2	0.1	0.5	1.6
40 Cycles	ΔΕ*	1.0	1.5	0.3	0.2	0.5	1.6
	Δ60°	-0.4	-0.7	+0.1	-0.2	+0.1	-2.3
	Δ85°	+0.4	-0.5	+0.8	0.0	+0.5	+1.3

After 1000 hours exposure in the Xenon Arc Weatherometer (ASTM G 26), PRC-DeSoto (Courtaulds) exhibited the greatest change of color. The loss of 60° gloss was more than the other test systems in this matrix with the exception of SPT. Following 40 cycles in the QUV (ASTM G 53), PRC-DeSoto (Courtaulds) showed the greatest color difference with the exception of SPT, which is known to have poor color stability in the field. SPT also exhibited the greatest loss of gloss at 60° and the greatest increase of gloss at 85°.

The laboratory artificial weathering predicted the fading and gloss loss of the PRC-DeSoto (Courtaulds) system. The other systems tested were nearly equivalent to each other and marginally better than the GSA control and the "unacceptable" SPT.

The desirability index ranks US Paints the best overall and best appearance attribute, which seems to be the observation of this flight testing. The ranking of PRC-DeSoto (Courtaulds) next with a high appearance attribute seems at odds with artificial weathering data, but the initial appearance was very good, for both laboratory testing and when applied at the ALC. The desirability of the other test coatings were ranked nearly equal, which appears to be appropriate after flight testing.

9.0 CONCLUSIONS

All of the tested paint systems have shown significantly improved weatherability over TT-P-2756, Self-Priming Topcoat. Casual observation noted that other KC-135s assigned to these same bases display a "patch work quilt" appearance.

Each coating system tested provided equal or improved protection against corrosion compared with the control coating system. The integrity of each coating system tested was equal or greater than the control coating system. The appearance of each coating system tested, with the exception of PRC-DeSoto, exhibited equal or greater stability of gloss and color than the control coating system.

US Paints system has endured the greatest exposure time of this test matrix and appears to perform better than the Deft control. Sherwin-Williams presents a better appearance than the control, but has been subjected to fewer months of exposure. Presently the Deft APC coating system offers promise, but the control performed equally with similar exposure and is known fade with additional exposure.

At this time US Paints has shown improved performance over the control. Sherwin-Williams may offer improved resistance to weathering over the Deft control and the others appear to be equal to the control at this time. Experience has shown exposure of 18 to 24 months is required to differentiate between coating systems.

Additional evaluations of these coating systems would be valuable to track weatherability as a function of time, flight hours, and missions. It is recommended that these inspections be continued at yearly intervals.

APPENDIX I

Painted McClellan AFB, September 1997, LEFT SIDE

			KC-	135, 1	KC-135, Tail No. 64-14832	0.64	-1483	2		
			Sep-97			Jul-98			Jan-99	
Location		initial L*	initial a*	initial b*	test L*	test a*	test b*	test L*	test a*	test b*
	43	49.479	-1.273	-3.716	49.552	-1.480	-3.367	52.170	-1.600	-3.870
	4				49.725	-1.496	-3.979	51.770	-1.590	-3.110
	45				48.770	-1.447	-2.204	52.420	-1.600	-3.900
ə	46	49.675	-1.320	-3.860	48.554	-1.344	-3.315	52.790	-2.230	-3.360
jac.	9				51.067	-1.594	4.015	51.930	-1.620	-3.670
ini\ hu:	39				50.686	-1.631	-4.129	54.000	-1.730	-3.860
S	38				50.369	-1.595	4.273	53.610	-1.730	4.030
	37				49.883	-1.549	4.167	53.740	-1.690	-4.050
	36				50.199	-1.529	4.158	53.630	-1.680	4.010
3	35				49.434	-1.422	-3.916	53.630	-1.680	4.010
Motors /	49	49.922	-1.330	-3.884	48.876	-1.328	-3.608	48.730	-1.340	-3.760
	20				49.316	-1.349	-3.813	49.100	-1.310	-3.850
	32	49.828	-1.313	-3.684	49.037	-1.287	-3.720	51.870	-2.150	-3.620
•	31	49.439	-1.234	-3.745	48.887	-1.319	-3.721	48.980	-1.450	-3.880
	34									
əbı	33	49.822	-1.289	-3.755	48.754	-1.292	-3.731	48.640	-1.320	-3.870
	42							52.580	-1.660	4.040
	4				48.509	-1.285	-3.470	49.960	-1.430	-3.850
	30				49.142	-1.310	-3.750	49.400	-1.380	-3.870
	29				48.844	-1.290	-3.703	49.400	-1.380	-3.870
	28				48.463	-1.221	-3.589	48.810	-1.340	-3.950
	27	49.822	-1.289	-3.755	48.646	-1,239	-3.632	48.310	-1.280	-3.670
	47									
i	48				48.227	-1.228	-3.044			
Average		49.712	-1.293	-3.771	49.336	-1.400	-3.713	51.145	-1.577	-3.803
Left Wing		49.577	-1.297	-3.788	49.867	-1.518	-3.734	52.896	-1.719	-3.762
Left Fuselage	a)	49.728	-1.281	-3.735	48.783	-1.282	-3.617	49.705	-1.470	-3.847

Initial values obtained from witness panels

Painted McClellan AFB, September 97, LEFT SIDE

				*	KC-135,	5, Tail	I No.	64-14832	1832				
			7/98-initi	initial			1/99.	1/99-7/98			1/99-initia	nitial	
Location	ion	delta L*	delta a*	delta b*	delta E*	delta L*	delta a*	delta b*	delta E*	delta L*	delta a*	delta b*	delta E*
	43	0.073	-0.207	0.349	0.412	2.618	-0.120	-0.503	2.669	2.691	-0.207	-0.154	2.703
19	4 4	0.246	-0.223	-0.263 1.512	0.424	2.045	-0.094	0.869	2.224	2.291	-0.317	0.606	2.391
e Ŋbb	46	-1.121	-0.024	0.545	1.247	4.236	-0.886	-1.036	4.328	3.115	-0.32/ -0.910	0.190	3.251
	9	1.392	-0.274	-0.155	1.427	0.863	-0.026	0.345	0.930	1.392	-0.300	0.190	1.437
niV Sur	99	1.011	-0.311	-0.269	1.091	3.314	-0.099	0.269	3.326	4.325	-0.410	0.00	4.344
	2 C	0.594 4000	0.275	-0.413	0.853	3.241	-0.135	0.243	3,253	3.935	-0.410	-0.170	3.960
די	36	0.524	-0.209	-0.30/	0.638	3.431	0.151	0.148	3.438	3.955	-0.3/0	-0.150 -0.150	3,974
5	35	-0.488	-0.092	-0.032	0.498	4.196	-0.258	-0.094	4.205	3.708	-0.350	-0.126	3.727
Motors	49	-1.046	0.002	0.276	1.082	-0.146	-0.012	-0.152	0.211	-1.192	-0.010	0.124	1.198
	20	-0.512	-0.036	-0.129	0.529	-0.216	0.039	-0.037	0.223	-0.728	0.003	-0.166	0.747
	32	-0.791	0.026	-0.036	0.792	2.833	-0.863	0.100	2.963	-0.459	-0.837	0.064	0.957
	, 3	-0.552	-0.085	0.024	0.559	0.093	-0.131	-0.159	0.226	-0.459	-0.216	-0.135	0.525
əl	.	-1 068	-0 O-	700	4 8 8	-0 114	ACO 0-	ر 130	0.182	1 100	20.0	0 446	100
elaç	2		?		8	<u>r</u> •	-0.020	?	0.102	2.758	-0.371	-0.113	2.797
sn _:	41	-1.313	0.004	0.285	1.344	1.451	-0.145	-0.380	1.507	0.138	-0.141	-0.095	0.219
- H	30	-0.680	-0.021	0.005	0.680	0.258	-0.070	-0.120	0.293	-0.422	-0.091	-0.115	0.447
Pη	33	-0.978	-0.001	0.052	0.979	0.556	-0.090	-0.167	0.587	-0.422	-0.091	-0.115	0.447
	78	-1.359	0.068	0.166	1.371	0.347	-0.119	-0.361	0.515	-1.012	-0.051	-0.195	1.032
	27	-1.176	0.050	0.123	1.183	-0.336	-0.041	-0.038	0.341	-1.512	0.00	0.085	1.514
	48	-1.595	0.061	0.711	1.747								
Average		-0.440	-0.093	0.103	0.954	1.809	-0.176	-0.090	1.965	1.338	-0.276	-0.045	2.099
Left Wing	ED	0.258	-0.214	0.078	0.912	3.028	-0.201	-0.028	3.117	3.209	-0.401	0.015	3.254
Left Fuselage	slage	-1.002	9000	0.123	1.025	0.541	-0.161	-0.145	0.760	-0.330	-0.182	-0.107	0.987

Initial values obtained from witness panels

Painted McClellan AFB, September 97, LEFT SIDE

			X S	KC-135, Tail No. 64-14832	Tail	lo. 64	148	32			
	9/97 initial	7/98 test	1/99 test	9/97 initial	7/98 test	1/99 test	total delta	9/97 initial	7/98 test	1/99 test	total
Location		DFT	DFT	60 degree	60 degree	60 degree	60 degree	85 degree	85 degree	85 dearee	degree
-		S E	SIE	Gloss	Gloss	Gloss	Gloss	Gloss	Gloss	Gloss	Gloss
	43 1.8	4.0	3.1	2.0	1.5	1.7	-0.3	1.9	3.4	4.1	2.2
	44	6.7	5.6		1.2	1.4	9.0-		2.7	3.9	2.0
beı		0.4	4.5		1.3	9.	-0. 4.0		2.8	3.5	1.6
ə	46 5.1	£.3	3.4	2.6	4.1	9.	-1.0	3.1	1.2	4.0	6.0
Sei	- 	<u>4</u> .	3.4		9.	4.	-1.2		3.6	4.0	6.0
ung	39	4. 80.	4.0		1.3	6.7	-1.3		3.0	3.1	0.0
S	38	3.7	6.2		1.3	6.	-1.3		3.5	2.8	-0.3
	37	5.6	4.6		£.	7.5	-1.1		3.1	3.2	0.1
	36	4 2	4.9		1.3	1.5	-1.1		3.2	2.9	-0.2
	35	4.4	4.1		1.7	1.6	-1.0		3.0	2.4	-0.7
	49	10.7	9.6	2.5	6.0	2.8	1.9	3.3	3.8	3.2	-0.1
Motors		13.1	10.7		0.8	<i>.</i> /			3.9	5.3	2.0
	32 3.3	5.5	5.4	1.7	2.2	1.9	0.2	1.5	3.6	2.4	-1.2
	000000	3.5	12.4	2.0	2.2	2.1	-0.1	1.6	3.2	2.6	1.0
-											
	33 2.9	3.5	5.3	1.7	2.3	2.6	6.0	1.9	3.4	3.2	£.
De _l	42	4.4	5.2		1.6	3.2	1.5		2.5	2.7	0.8
	<u>-</u>	4 .0	4 .0		7.5	<u>/</u>	/		3.2	3.8 8.	6.
	30	3.5	4.4		2.3	2.1	4.0		4.4	3.6	1.7
	29 	0.4	3.3		2.2	Q.	0.2		3.5	က	-
		3.6	3.1		2.1	2.2	0.5		3.0	3.1	1.2
	27 3.8	4.0	3.0	1. 6.	2.3	.	0.0	<u>←</u> ∞.	3.6	2.5	0.7
	47	&. c ♣. c			e. c				4.0 0.0		
Average		5.1	53	20	1.6	1 8	-0.5	2.2	0 6	11	αc
Wina	. S.	4.6	5. 4 4.	, c	. <u>.</u>	<u></u>	9 0	1 6	, e.	. e.	
Fuselage	3.4	4.0	5.2	, .	2.1	2.2	0.5	1.7	, c,	30	6.0
			!		· İ		 - 	•) •)))

Initial values obtained from witness panels DFT = Dry Film Thickness

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Courtaulds - (Right Side)

	<u> -</u>	Fuselage	804	7	Fuselag	8	3	Fuselage		4	Leading Edge	• do	22	Wing Tip	Tip	~	Upper Wing	Upper Wing 3&4 Engines
		7/98	1/99		7/98	1/98		7/98	1/99	L	86/2	1/89		7/98	1/99		7,08	1/00
		test	test		test	test		test	test		test	test		test	test		te at	ţ,
Pencil Hardness		u.	2H		и.	2H		и.	I	L	U.	¥5		8	I			天
Modified PATTI		784 psi	597 psi		1274 psi	1144 psi		1470 psi	1343 psi	L	1178 psi	746 psi		686 psi	1184 psi			895 psi
Fallure Mode: AG			22 %			2%			15%	L		45 %			55 %			45%
d₩	<u></u>		10 %							L								
ATP	•									L								
CP	<u></u>									ì								
CT			85 %			95 %			85 %	L		55 %			45 %			55 %
Wet Tape		Pass			Pass			Pass		L	Pass			Pass				
	_	T:///		1	- 1940		T	7		F,	340		Ŀ		-	Ţ		
Chalking	-	Moderate (8")	4	۷	Moderate (8")	4	2	Moderate (8")	4	4 1 5	Moderate (8")	4	n	ruserage Moderate (8*)	4	<u> </u>		
Deft (Left Side)	ide)			•			1			ł			1					
	9	Fuselage	9,0	-	Fuselag	8	8	Fuselage		٦	Leading Edge		=	Wing Tip	Tip	~	Upper Wing	Upper Wing 1&2 Engines
		7/98	1/99		7/88	1/99		86/2	1/99	L	7/98	1/99		7/98	1/99		7/98	1/99
		test	test		test	test		test	test	i	test	test		test	test	•	test	test
Pencil Hardness		퐀	ZH		2H	2H		2H+	2H		Ι	I		2H+	2H		•	F F
Modified PATTI		1764 psi	1293 psi		1764 psi	1293 psi		1764 psi	1443 psi	لـــــا	1862 psi	1493 psi		1225 psi	1493 psi	~~~	•	1493 psi
Fallure Mode: AG			5%			20 %			15 %			25 %			20%			35 %
AP						75 %				L								
ATP										L								
CP			75 %							L.,								
CT			20 %			2%			85 %	ا		75 %			80 %			85 %
Wet Tape		Pass			Pass	•		Pass	•	L	Pass	•		Pass			•	
										ĺ						Γ		

Right Side - Courtaulds Left Side - Deft

Pencil Hardness (Soft to Hard): 5b-4b-3b-2b-b-Hb-F-H-2H-3H-4H-5H-6H-7H-8H-9H

AG = Adhesion of glue to stud or topcoat ATP = Adhesion of Topcoat to Primer AP = Adhesion of Primer to substrate CP = Cohesion of Primer CT = Cohesion of Topcoat

None

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None

Wing

Wing

Wing

Wing Tip

None

None

None

* = ASTM D 659 Photographic Reference Standard

APPENDIX II

Painted McClellan AFB, September 97, RIGHT SIDE

	1/99 total test delta 85 85 degree degree Gloss Gloss	0,-0,	4.5 4.1 1.2 1.0
	7/98 test 65 degree de Gloss G	r r r r r r r r r r r r r r r r r r r	ນ 4. ພິ ນ ສ
2	9/97 initial 85 degree Gloss	3.3 3.0 3.7 3.1 3.5 3.4 3.5 2.4	. e. e. - e. t.
Tail No. 64-14832	total delta 60 degree Gloss	0.0 0.0 0.0 0.0 0.0 0.1 0.1 0.3 0.3 0.3 0.3 0.3 0.3 0.3 0.3 0.0 0.3 0.3	0.7
o. 64-	1/99 test 60 degree Gloss	0.0 0.0 0.0 0.0 0.0 0.0 0.0 0.0	5 6 6
ail N	7/98 test 60 degree Gloss	0.9 0.9 0.9 0.9 0.9 0.8 0.8 0.8 0.8 0.8 0.8 0.8 0.8	- 0 0 0 8
35, T	9/97 initial 60 degree Gloss	6:0 8:0 8:0 8:0 8:0 8:0 8:0	, , , , , , ,
KC-135,	1/99 test DFT mils	8.4.6 9.4.6 9.4.6 9.4.6 9.4.6 1.3.6 1.3.6 1.4.6 1.	3. 6. 3. 6. c.
	7/98 test DFT mils	6. 6. 6. 6. 4. 4. 6. 6. 6. 6. 6. 6. 6. 6. 6. 6. 6. 6. 6.	1 to 4 0 to 5
	9/97 initial DFT mils	1.6 4.5 3.8 3.2 3.3 3.3	5 - 4 5 - 5 - 5
	Location	Right Fuselage Surface	Wing Fuselage

Initial values obtained from witness panels DFT = Dry Film Thickness

Painted McClellan AFB, September 97, RIGHT SIDE

		KC-135, Tail No. 64-14832	35, T	ail N	0. 64	1-148	32		
	,	Sep-97			Jul-98			Jan-99	
Location	initial L*	initial a*	initial b*	test L*	test a *	test b *	test L*	test a*	test b*
	3			51.514	-2.031	-3.228	52.170	-1.600	-3.870
196	4 48.557	7 -1.616	-4.027	51.885	-2.203	-3.774	53.310	-2.240	-2.860
	S.			50.526	-2.014	-3.065	53.240	-2.280	-3.570
8 21	စ			51.664	-2.067	-3.564	51.290	-1.990	-3.800
eħ.				52.042	-2.150	-3.760	54.180	-2.310	-3.610
	∞			52.385	-2.177	-3.794	53.220	-2.300	-3.690
34£	<u>.</u>			52.418	-2.252	-3.963	53.600	-2.300	-3.680
	<u> </u>			53.209	-2.243	-3.800	54.010	-2.300	-3.690
				52.412	-2.219	-3.871	54.290	-2.270	-3.590
Æ	14			49.007	-1.804	-3.687	53.110	-2.150	-3.700
Motors	15 48.617	7 -1.585	-4.230	50.091	-1.976	-3.853	48.870	-1.320	-3.780
	19 48.897	7 -1.667	-4.106	49.201	-1.828	-3.723	52.490	-2.190	-3.590
•	18 48.830	0 -1.633	-4.144	48.979	-1.849	-3.843	52.930	-2.250	-3.610
əl	17 48.931	1 -1.587	-4.108	49.718	-1.959	-3.860	53.390	-2.270	-3.500
jel Jel	16			49.102	-1.851	-3.791	53.820	-2.210	-3.520
əsı	12 48.644	4 -1.572	-4.159	51.309	-2.247	-3.794	50.490	-1.510	-4.070
n-i	13			51.478	-2.213	-3.927	54.190	-2.280	-3.360
	20 48.888	8 -1.566	-4.159	49.995	-1.912	-3.874	53.290	-2.190	-3.390
	21 48.884	4 -1.535	-4.211	49.896	-1.858	-3.791	52.300	-2.140	-3.720
,	23 48.778	8 -1.636	-4.040	48.670	-1.778	-3.837	51.590	-1.940	-3.550
,	22 48.735	5 -1.671	-4.100	48.829	-1.736	-3.787	48.310	-1.280	-3.670
Average	48.776	6 -1.607	-4.128	50.682	-2.017	-3.742	52.576	-2.063	-3.610
Right Wing	48.557	7 -1.616	-4.027	52.006	-2.151	-3.646	53.257	-2.177	-3.596
Right Fuselag	ig 48.823	3 -1.608	-4.128	49.718	-1.923	-3.823	52.280	-2.026	-3.598

Initial values obtained from witness panels

Painted McClellan AFB, September, 1997, RIGHT Side

			KC	KC-135,		Tail No. 64-14832	64-1	1832				
·		1/4	7/98-initial			1/99.	1/99-7/98			1/99-initia	nitial	
Location	delta L*	ta delta	a delta	delta F*	delta *	delta a*	delta h*	delta	delta	delta	deita	delta
	3 2.957	9	5 0.801	3.092	0.656	0.431	-0.644	1.015	3,613	0.016	0 157	3.846
190	3.328	P		3.389	1.425	-0.037	0.914	1.693	4.753	-0.624	1.167	4.934
į		Ģ	98 0.962	2.227	2.714	-0.266	-0.505	2.773	4.683	-0.664	0.457	4.752
908		P		3.174	-0.374	0.077	-0.236	0.449	2.733	-0.374	0.227	2.768
ini\		P		3.536	2.138	-0.160	0.150	2.149	5.623	-0.694	0.417	5.681
ıs	-	Q		3.876	0.835	-0.123	0.104	0.850	4.663	-0.684	0.337	4.725
		P	0.064	3.914	1.182	-0.048	0.283	1.216	5.043	-0.684	0.347	5.101
		P		4.700	0.801	-0.057	0.110	0.811	5.453	-0.684	0.337	5.506
		입		3.905	1.878	-0.051	0.281	1.900	5.733	-0.654	0.437	5.787
RH 14				0.703	4.103	-0.346	-0.013	4.118	4.493	-0.565	0.530	4.559
Motors 1	-	위		1.571	-1.221	0.656	0.073	1.388	0.253	0.265	0.450	0.580
<u></u>	19 0.304	P	1 0.383	0.515	3.289	-0.362	0.133	3.312	3.593	-0.523	0.516	3.667
		Q		0.399	3.951	-0.401	0.233	3.978	4.100	-0.617	0.534	4.180
•				0.905	3.672	-0.311	0.360	3.703	4.459	-0.683	0.608	4.552
		P		0.447	4.718	-0.359	0.271	4.739	4.889	-0.623	0.588	4.963
	12 2.665			2.773	-0.819	0.737	-0.276	1.136	1.846	0.062	0.089	1.849
H 1				2.915	2.712	-0.067	0.567	2.771	5.546	-0.708	0.799	5.648
				1.194	3.295	-0.278	0.484	3.342	4.402	-0.624	0.769	4.512
Ri 2			3 0.420	1.142	2.404	-0.282	0.071	2.422	3.416	-0.605	0.491	3.504
ď		Q		0.270	2.920	-0.162	0.287	2.939	2.812	6 .304	0.490	2.871
	-	위		0.333	-0.519	0.456	0.117	0.701	-0.425	0.391	0.430	0.720
Average	1.996	Q		2.142	1.893	-0.045	0.132	1.898	3.890	-0.456	0.485	4.023
Right Wing				3.535	1.251	-0.026	0.051	1.429	4.700	-0.561	0.431	4.763
Right Fuselage	e 0.902		1 0.307	1.089	2.562	-0.103	0.225	2.904	3.464	-0.423	0.531	3.647

Initial values obtained from witness panels

APPENDIX III

Painted McClellan AFB, March 98, RIGHT SIDE

•			X	C-1;	35, Ta	N IIE	qur	er 59	KC-135, Tail Number 59-1472			
		3/98	7/98	1/99	3/88	86/2	1/99	total	3/98	2//98	1/99	tatel delta
•		initial	test	teat	Initial	test	test	delta	initial	test	test	יסיפונש
Location	u o	DET	DET.		99	90	8	09	82	82	82	60
		mils	mils	i i	degree	degree	degree	degree	degree	degree	degree	degree Gloss
					Gloss	Gloss	Gloss	Gloss	Gloss	Gloss	Gloss	GIOSS
	က	0.4	4.1	5.6	1.2	2.0		-0.9	2.6	2.9	2.9	0.0
er	4	2.8	3.2	2.7	- -	6.0	6.0	0.0	2.3	2.3	2.6	0.3
ddį	S.	4.0	2.5	3.7	-	1.2	-	-0.1	2.3	3.5	2.9	9.0-
J, t	ဖ	4.0	2.9	3.7	0.1	0.1	6.0	-0.1	2.1	2.4	2.5	0.1
Jui/ etur	7	3.7	4.0	3.4	7:	8.0	1.2	4.0	2.4	2.8	3.0	0.2
	œ	4.5	4.1	3.7	1.2	0.1	6.0	-0.1	2.5	3.3	2.4	6.0-
lgi.	6	5.0	4.2	3.6	1:1	0.1	7:	0.1	2.5	3.0	2.5	-0.5
뇀	9	3.7	3.1	3.6	1.1	0.8	6.	0.2	2.5	2.5	2.8	0.3
	=======================================	4.5	3.1	3.3	1.1	1.0	1.9	0.9	2.4	2.5	2.4	-0.1
RH Motors	14	11.5	9.6	11.5	1.0	3.4	6.0	-2.5	2.4	2.9	2.2	-0.7
	15	14.6	8.7	11.1	1.2	5.1	0.9	-4.2	2.7	4.3	2.2	-2.1
	19	3.7	4.0	3.9	1.2	1.3	9.0	5.0-	2.5	2.6	2.2	-0.4 4.0-
	8	5.1	3.7	4.7	1.2	8.	0.9	-0.9	2.6	2.7	2.1	-0.6
əl	17	5.1	5.2	6.4	6.1	6.	0.9	-1.0	2.3	3.3	2.1	-1.2
gele	16	5.1	5.2	4.2	1.2	3.0	0.9	-2.1	2.5	3.4	2.4	-1.0
esn	12	5.2	4.0	4.5	1.3	6.0	1.2	0.3	2.2	2.8	2.4	-0.4
	13	4.7	5.3	4.8	4.	4.1	1:	-0.3	2.2	2.3	2.1	-0.2
	20	5.1	5.4	4.2	1.2	9.	1.2	-0.4	2.5	2.6	2.2	-0.4
<u>я</u>	77	4.4	4.7	4.0	1.3	2.1	7:	-1.0	2.1	3.0	2.2	-0.8
	23	5.2	5.4	4.9	1.3	6.	6.0	-0.4	2.1	2.7	2.2	-0.5
	22	4.8	5.0	4.9	1.2	4.4	1.6	-2.8	1.5	2.2	1.9	-0.3
Average		5.3	4.6	4.8	1.2	1.8	1.1	-0.7	2.3	2.9	2.4	-0.5

DFT = Dry Film Thickness

Painted McClellan AFB, March 1998, RIGHT SIDE

		X	KC-135, Tail Number 59-1472	rail Nu	ımber	59-147	2		
•		Mar-98			Jul-98			Jan-99	
Location	initial I *	initial a*e	initial b*	test	test	test	test	test	test
	4	g		ני	ਰ	n		a	 0
	49.959	-1.513	-4.086	48.877	-1.485	-4.018	20.060	-1.670	-4.470
	-			49.517	-1.445	-4.003	49.640	-1.640	-4.080
í				49.022	-1.393	-3.697	49.110	-1.630	-4.390
g, ace				48.903	-1.412	-4.033	48.960	-1.430	-4.290
:µr				49.399	-1.462	-4.123	52.720	-2.010	-4.460
າຣ				49.269	-1.444	-4.090	53.420	-2.070	-4.450
				49.157	-1.455	-4.070	53.940	-2.110	-4.350
당				48.981	-1.408	-4.017	52.320	-1.960	-4.500
-	1			49.041	-1.440	-4.097	49.350	-0.940	-2.750
				50.384	-1.423	-4.077	49.130	-1.450	-4.260
Motors 15	2			50.149	-1.415	-4.002	50.060	-1.130	-3.580
-				49.927	-1.448	-4.035	49.290	-1.440	-4.340
	 •						49.090	-1.550	-4.490
•				49.870	-1.427	-4.047	48.930	-1.500	-4.260
•				49.870	-1.427	-4.047	49.050	-1.420	-4.300
	-			49.870	-1.427	-4.047	49.630	-1.580	-4.290
크 1				49.870	-1.427	-4.047	52.670	-1.990	-4.190
				49.569	-1.416	-3.978	49.020	-1.420	-4.230
				49.612	-1.422	-3.878	49.000	-1.440	4.180
23	<u></u>			52.502	-0.500	0.300	49.080	-1.360	-4.250
1				52.568	-0.501	0.251	49.360	-1.110	-3.200
Average	49.959	-1.513	-4.086	49.818	-1.339	-3.588	50.237	-1.564	-4.157
Right Wing				49.130	-1.438	-4.016	51.058	-1.718	-4.191
Right Fuselage	Ð			50.406	-1.222	-3.059	49.512	-1.481	4.173

Painted McClellan AFB, March 98, RIGHT SIDE

					Ϋ́	135, T	KC-135, Tail Number	nmbe	r 59-1	59-1472			
			7/98-initial	nitial			1/99-7/98	86/2			1/99-initia	nitial	
Location	. uc	Delta	Delta	Delta h*	Deita F*	Delta	Delta	Delta	Delta	Delta	Delta	Delta	Delta
	,	000	2000	200		1	5	3	,	1	8	2	u
J	o .	-1.002	0.028	0.00	1.084	1.183	-0.185	-0.452	1.280	0.101	-0.157	-0.384	0.427
be	4	-0.442	0.068	0.083	0.455	0.123	-0.195	-0.057	0.237	-0.319	-0.127	0.028	0.344
	ۍ.	-0.937	0.120	0.389	1.022	0.088	-0.237	-0.693	0.738	-0.849	-0.117	-0.304	0.909
90°	ဖ	-1.056	0.101	0.053	1.062	0.057	-0.018	-0.257	0.264	-0.999	0.083	-0.204	1.023
	_	-0.560	0.051	-0.037	0.564	3.321	-0.548	-0.337	3.383	2.761	-0.497	-0.374	2.830
	ထ	-0.690	0.069	-0.004	0.693	4.151	-0.626	-0.360	4.213	3.461	-0.557	-0.364	3.524
q6	တ	-0.802	0.058	0.016	0.804	4.783	-0.655	-0.280	4.836	3.981	-0.597	-0.264	4.034
!H	10	-0.978	0.105	0.069	0.986	3.339	-0.552	-0.483	3.419	2.361	-0.447	-0.414	2.438
	7	-0.918	0.073	-0.011	0.921	0.309	0.500	1.347	1.470	-0.609	0.573	1.336	1.578
£	4	0.425	0.090	0.00	0.435	-1.254	-0.027	-0.183	1.268	-0.829	0.063	-0.174	0.849
Motors	15	0.190	0.098	0.084	0.230	-0.089	0.285	0.422	0.517	0.101	0.383	0.506	0.643
	9	-0.032	0.065	0.051	0.089	-0.637	0.008	-0.305	0.706	-0.669	0.073	-0.254	0.719
	∞ !									-0.869	-0.037	-0.404	0.959
đe	17	-0.089	0.086	0.039	0.130	-0.940	-0.073	-0.213	0.967	-1.029	0.013	-0.174	1.044
ela	9	-0.089	0.086	0.039	0.130	-0.820	0.007	-0.253	0.858	-0.909	0.093	-0.214	0.938
sn	7	-0.089	0.086	0.039	0.130	-0.240	-0.153	-0.243	0.374	-0.329	-0.067	-0.204	0.393
ㅋ 1	,	-0.089	0.086	0.039	0.130	2.800	-0.563	-0.143	2.860	2.711	-0.477	-0.104	2.755
ф	29	-0.390	0.097	0.108	0.416	-0.549	-0.004	-0.252	0.604	-0.939	0.093	-0.144	0.955
iЯ	7	-0.347	0.091	0.208	0.415	-0.612	-0.018	-0.302	0.683	-0.959	0.073	-0.094	0.966
	23	2.543	1.013	4.386	5.170	-3.422	-0.860	-4.550	5.758	-0.879	0.153	-0.164	0.907
	22	2.609	1.012	4.337	5.161	-3.208	-0.609	-3.451	4.751	-0.599	0.403	0.886	1.143
Average		-0.141	0.174	0.498	1.001	0.419	-0.226	-0.552	1.959	0.223	-0.051	-0.071	1.399
Right Wing		-0.829	0.075	0.020	0.843	1.928	-0.280	-0.175	2.204	1.099	-0.205	-0.105	1.901
Right Fuselage	e d	0.447	0.291	1.027	1.308	-0.848	-0.252	-1.079	1.951	-0.447	0.032	-0.087	1.078

33

KC-135, Tail Number 59-1472

Sherwin-Williams -- (Right Side)

		•	,															
	*-	Fuselage	lage	2	Fuselage	age	က	Fuse	Fuselage	4	Oppe	Upper Wing	~	Upper Wing 3&4 Engines	3&4 Engines	2	Upper V	Upper Wing Tip
		2/98	1/99		86/2	1/99		1/98	1/99		86/2	1/99		86/2	1/99		86/2	1/99
		test	test		test	test		test	test		test	test		test	test		feet	toet
Pencil Hardness		ц.	I		ш.	모		L	L.		2H	퐀			2H		天	7
티	ب	1274 psi	746 psi		1470 psi	697 psi		1813 psi	697 psi		1862 psi	1691 psi			1592 psi		1078 psi	1393 nei
Failure Mode: AG		40 %			2 %			10%	10 %			20 %			40%		15%	30 %
AP			100 %			20 %				•					2 %			
ATP										•								
S	1								% 09	!						-		
CT	I	% 09			82 %	20 %		% 06	30 %	·	100 %	20 %			55 %	-	85 %	% 02
Wet Tape		Pass	•		Pass			Pass	•	_	Pass					٠	Pass	
	-	Wing Tip	di di	2	Wing	6	8	Wing	Du	4	Wina	20	5	Fuselage	lage			
Chalking		None	7		None	7		None	9		None	9		None	9			
Spraylat (Left Side)	ift S	ide)					Ī			Ī]					
	9	Fuselage	age	2	Fuselage	age	80	Fuselage	lage	6	Upper	Upper Wing	2	Upper Wing 1&2 Engines	82 Engines	5	Upper Wing Tip	Ving Tip
	L	86/2	1/99		86/2	1/99		2/98	1/99	ــــــا	86/2	1/99	-	7/98	1/99		86/2	1/89
		test	test		test	test		test	test		test	test		test	test		test	fact
Pencil Hardness	1	_	ß		2B	В		2B	B	1	28	쭏			봈	I	里	I
디	1	490 psi	398 psi		1078 psi	796 psi		1029 psi	945 psi		1421 psi	896 psi			945 psi		882 psi	796 psi
Failure Mode: AG			2%			10 %		% 5 <i>L</i>	20 %		10 %	20 %			2%	!	2%	2%
₽ P			85 %		45 %	35 %				ليا					20 %	_	2%	
ATP				1												<u> </u>		
S S																	-	
CT			10%		25 %	25 %		25 %	% 08	.	% 06	20 %	نننسم		75 %	ــــــــــــــــــــــــــــــــــــــ	% 06	95 %
Wet Tape	\dashv	Pass	<u> </u>	\dashv	Pass	•	\neg	Pass	•	۲	Pass						Pass	
													i					

Pencil Hardness (Soft to Hard): 5b-4b-3b-2b-b-Hb-F-H-2H-3H-4H-5H-6H-7H-8H-9H Right Side - Sherwin-Williams

Left Side - Spraylat

Appendix III

AG = Adhesion of glue to stud or topcoat
AP = Adhesion of Primer to substrate
ATP = Adhesion of Topcoat to Primer
CP = Cohesion of Primer
CT = Cohesion of Topcoat

Fuselage

Wing

None

None

ဖ

Wing None

Wing Tip None 7

Chalking

None

Large Aircraft Coatings Flight Testing

APPENDIX IV

			3	KC-135,	Tail	Tail Number 59-1472	er 59.	.1472			
Location	1/98 initial DFT mils	7/98 test DFT mils	1/99 test DFT mils	1/98 initial 60 degree Gloss	7/98 test 60 degree Gloss	1/99 test 60 degree Gloss	total delta 60 degree Gloss	1/98 initial 85 degree Gloss	7/98 test 85 degree Gloss	1/99 test 85 degree Gloss	total delta 85 degree Gloss
15	\bot	,	,	-	9	Ş	30	3	5	, ,	3
-		3	0.0	-	D.	†	c.0-	¥	2.6	4.0	7. 0. 7.
	3.6	3.4	က ထ	<u>.</u>	2.0	6.	0.	4 .0	0.0	8.0	2.0
9dd		2.6	2.7	1.0	4.	-	-0.3	4.2	4.3	4.0	-0.3
901	4	2.6	3.3	=	2.6	1.2	4.1-	8.4	5.3	4.5	6.0°
gni shu	3.8	2.8	2.0	1.2	2.8	1.2	-1.6	5.3	5.1	4.5	-0.6
	2.7	3.2	2.2	1.2	1.1	<u>ب</u> ه.	0.7	5.2	5.9	4.5	4.1-
na_	4.6	2.8	3.2	1.2	2.2	6.	-0.3	5.2	5.9	5.9	0.0
	3.9	2.9	3.6	7:	1.0	6.0	-0.1	8.4	5.5	4.2	-1.3
36	2.7	2.6	2.6	7:	1.5	1.0	-0.5	4.6	5.6	4.2	4.1-
35	4.2	5.8	2.3	1.1	1.0	2.0	1.0	5.0	5.5	4.4	-1.1
Гн 49	11	9.7	9.6	1.1	11.2	2.1	-9.1	5.4	7.0	5.6	-1.4
Motors 50	11.6	10.7	9.6	1.1	5.5	1.6	-3.9	5.1	6.2	4.7	-1.5
32	6.8	4.4	5.4	1.4	5.4	1.7	-3.7	7.3	7.0	4.6	-2.4
	6.4	5.1	5.1	1.2	4.1	1.6	-2.5	5.4	9.9	4.4	-2.2
34		4.7		1.2	4.5		in in the second	4.8	5.8		
		5.8		1.2	2.2			4.5	5.8		
	4	5.9	5.3	1.0	1 .8	2.7	6.0	3.5	4.0	3.7	-0.3
ləs <u>4</u>	4.5	5.3	2.9	1.0	1.9	2.3	4.0	4.7	5.1	3.9	-1.2,
ᆵ	4.3	4.0	3.6	0.	2.4	1.6	-0.8	3.2	3.5	2.4	-1.1
ffe.	5.4	4.0	4.3	6.0	1.2	1.3	0.1	6 .	6.4	2.8	-2.1
	5.4	4.0	3.8	8.0	0.9	4. 8.	6.0	9.0	1.3	1.6	0.3
27		3.0	3.5	6.0	1.6	1.6	0.0	7:	2.1	6.1	-0.2
47		2.7			8.8				3.1		
48		2.7			1.2		,		1.7		
Average	5.0	4.5	4.1	1.1	2.7	1.6	-1.0	4.3	5.2	4.3	-0.8
Left Wing	3.61										

Appendix IV

DFT = Dry Film Thickness

Left Fuselage

Painted McClellan AFB, March 1998, LEFT SIDE

		KC	-135, T	KC-135, Tail Number 59-1472	mber (59-147	2		
		Mar-98			Jul-98			Jan-99	
Location	initial L*	initial a*	initial D*	test L*	test a*	test D*	test L*	test a*	test b*
43	49.959	-1.513	-4.086	49.516	-1.090	-3.228	49.040	-0.750	-1.370
196 44 45				49.124	-0.906 -1 022	-2.073	50.410	-0.570	-1.440
				49.235	-1.089	-3.269	49.850	-1.650	-4.500
oet Tac				50.298	-1.229	-3.661	51.690	-0.840	-2.760
ıng				50.112	-1.190	-3.563	50.610	-1.020	-2.690
•				49.991	-1.206	-3.580	50.870	-1.000	-2.900
98				49.602	-1.085	-3.274	49,990	0.900	2.720
35				49.477	-1.030	-3.276	49.990	-0.970	-2.720
				50.256	-1.146	-3.800	49.850	-0.930	-3.300
Motors 50				50.141	-1.058	-3.663	49.250	-1.480	-4.440
32				50.155	-1.057	-3.512	49.880	-0.920	-3.190
33				50.207	-1.023	-3.515	49.970	-1.650	4.240
34				50.207	-1.023	-3.515			
ege				49.902	-0.927	3.041	777		
				49.503	-0.973	-3 224	49.260	060:1-	-2.96U
Sn 4									000.7
ne 29				49.382	-1.032	-3.448	49.870	-0.930	-3.200
				49.525	-1.162	-3.576	49.130	-1.210	-3.360
27				49.773	-1.374	-3.831	49.160	-0.920	-3.100
47				47.156	0.464	1.217			
48				50.117	-1.002	-3.584			
Average	49.959	-1.513	-4.086	49.644	-1.085	-3.351	49.988	-1.025	-2.991
Left Wing	4			49.598	-1.104	-3.201	50.227	-0.946	-2.636
Left Fuselage				49.585	-0.917	-3.023	49.773	-1.087	-3.246

Appendix IV

Painted McClellan AFB, March 98, LEFT SIDE

				KC-1	-135, T	Tail N	Number		59-1472				
			7/98-initial	nitial			1/99	1/99-7/98			1/99	1/99-initial	
Loc	Location	Delta L*	Delta a*	Delta b *	Delta E*	Delta L⁴	Delta a*	Delta b*	Delta E*	Delta L*	Delfa a*	Delta b*	Delta E
	43	-0.443	0.423	0.858	1.054	-0.476	0.340	1.858	1.948	-0.919	0.763	2.716	2.967
J	44	-0.835	0.607	2.013	2.262	1.286	0.336	0.633	1.472	0.451	0.943	2.646	2.845
ıəd	45	-1.159	0.491	1.495	1.954	0.810	0.232	0.001	0.843	-0.349	0.723	1.496	1.698
	46	-0.724	0.424	0.817	1.171	0.615	-0.561	-1.231	1.486	-0.109	-0.137	-0.414	0.449
9, (g	40	0.339	0.284	0.425	0.613	1.392	0.389	0.901	1.703	1.731	0.673	1.326	2.282
	39	0.153	0.323	0.523	0.633	0.498	0.170	0.873	1.019	0.651	0.493	1.396	1.617
	38 38	0.032	0.307	0.506	0.593	0.879	0.206	0.680	1.130	0.911	0.513	1.186	1.581
ĵə-	37	-0.130	0.316	0.588	0.680	0.381	0.297	0.828	0.959	0.251	0.613	1.416	1.563
1	36	-0.357	0.428	0.812	0.985	0.388	0.115	0.554	0.686	0.031	0.543	1.366	1.470
	35	-0.482	0.483	0.810	1.059	0.513	0.060	0.556	0.759	0.031	0.543	1.366	1.470
5	49	0.297	0.367	0.286	0.552	-0.406	0.216	0.500	0.679	-0.109	0.543	0.786	0.962
Motors	50	0.182	0.455	0.423	0.647	-0.891	-0.422	-0.777	1.255	-0.709	0.033	-0.354	0.793
	32	0.196	0.456	0.574	0.759	-0.275	0.137	0.322	0.445	-0.079	0.593	0.896	1.077
	31	0.248	0.456	0.571	0.772	-0.237	-0.627	-0.725	0.987	0.011	-0.137	-0.154	0.208
	34	0.248	0.490	0.571	0.792								
Э	33	-0.057	0.586	1.045	1.199								
98	42	-0.456	0.540	0.862	1.115	1.637	-0.117	0.244	1.659	1.181	0.423	1.106	1.672
ləs	41	-0.456	0.540	0.862	1.115	-0.243	0.083	0.574	0.629	-0.699	0.623	1.436	1.714
n _∃	30												
ħ	29	-0.577	0.481	0.638	0.986	0.488	0.102	0.248	0.557	-0.089	0.583	0.886	1.064
97	28	-0.434	0.351	0.510	0.756	-0.395	-0.048	0.216	0.453	-0.829	0.303	0.726	1.143
	27	-0.186	0.139	0.255	0.345	-0.613	0.454	0.731	1.057	-0.799	0.593	0.986	1.401
	47	-2.803	1.977	5.303	6.316								
	48	0.158	0.511	0.502	0.734								
Average		-0.315	0.497	0.924	1.178	0.282	0.072	0.368	1.038	0.029	0.486	1.095	1.472
Left Wing	-	-0.361	0.409	0.885	1.101	0.629	0.158	0.565	1.201	0.268	0.567	1.450	1.794
Left Fuselage	lage	-0.374	0.593	1.063	1.353	0.052	-0.002	0.230	0.827	-0.186	0.426	0.831	1.183

Appendix IV

Large Aircraft Coatings Flight Testing

APPENDIX V

Painted Tinker AFB, May 97, RIGHT SIDE

	total t delta 85 ee degree is Gloss		6.6 6.2 7.2 6.9 7.2 7.2 8.5 7.4	1
	2/99 test 85 degree Gloss	80 12 22 22 23 24 25 25 25 25 25 25 25 25 25 25 25 25 25		6.2 7.0 5.6
	7/98 test 85 degree	9.6 11.8 11.1 7.7 7.7 6.3 6.3 7.8	6. 7. 4. 8. 8. 9. 7. 7. 8. 8. 8. 8. 7. 7. 8. 8. 8. 8. 8. 8. 8. 8. 8. 8. 8. 8. 8.	7.6 8.3 7.1
38	1/98 initial 85 degree Gloss	7.3. 6.5. 6.2. 6.3. 6.3. 6.3. 6.3. 6.3.	4 4 6 7 6 9 6 4 9 0 7 4 9 6 6 9 6 8 4 9 7 5	6.8 6.8 6.8
4-148	total delta 60 degree Gloss	2. 1. 2. 2. 2. 2. 2. 2. 2. 2. 2. 2. 2. 2. 2.	2 2 2 3 3 4 5 5 5 5 6 7 7 8 7 8 7 8 7 8 7 8 7 8 7 8 8 7 8	-3.3 -4.2
Tail No. 64-14838	2/99 test 60 degree Gloss	7. 2. 2. 2. 2. 2. 2. 2. 2. 2. 2. 2. 2. 2.	e: -: -: -: -: -: -: -: -: -: -: -: -: -:	2.3 2.3
	7/98 test 60 degree Gloss	6. 6. 6. 6. 6. 6. 6. 6. 6. 6. 6. 6. 6. 6	0.8.9.8.8.9.8.8.0.4.8.0.4.8.9.4.8.9.4.8.9.4.8.9.9.9.9.9.9.9.9.9	3.3 4.5
KC-135,	1/98 initial 60 degree Gloss	0. 7. 4. 4. 4. 6. 4. 6. 4. 6. 7. 6. 6. 6. 6. 6. 6. 6. 6. 6. 6. 6. 6. 6.	1.4 4.7 5.8 6.2 6.8 6.9 4.0	5.6 6.5 6.5
KC	2/99 test DFT mils	6. 6. 6. 4. 6. 4. 6. 6. 6. 6. 6. 6. 6. 6. 6. 6. 6. 6. 6.	4.4.4.4.0.0.0.0.0.0.0.0.0.0.0.0.0.0.0.0	5. 3.8 5.3 6.3
	7/98 test DFT mils	3.6 3.6 2.9 4.4 4.3 4.1 10.7	2. 0. 0. 4. 8. 0. 2. 2. 4. 4. 4. 4. 4. 4. 4. 4. 4. 4. 4. 4. 4.	5.4 1.4 5.6
	1/98 initial DFT mils	3.6 4.0 3.7 4.1 3.9 3.9 3.0 3.0 9.5	2. 2. 2. 2. 2. 2. 2. 2. 2. 2. 2. 2. 2. 2	5.6 9.9 9.9
	Location	A Right Wing, Upper Surface ארלפים ביי		Average Wing Fuselage

DFT = Dry Film Thickness

Appendix V

Painted Tinker AFB, May 97, LEFT SIDE

| 4.5 4.2 4.3 3.3 2.1 -2.2 5.7 6.1 5.3 3.5 2.7 4.4 3.0 2.1 -2.2 6.7 7.5 6.6
 | 4.5 4.2 4.3 3.3 2.1 -2.2 5.7 6.1 5.3 3.5 2.7 4.4 3.0 2.1 -2.2 6.7 7.5 6.6 4.0 4.5 4.1 3.5 3.1 5.3 5.1 5.0 4.0 4.5 5.1 5.0 4.0 4.0 5.0 5.0 5.0 4.0 5.0 5.0 5.0 5.0 5.0 5.0 5.0 5.0 5.0 5

 | 4.5 4.2 4.3 3.3 2.1 -2.2 5.7 6.1
3.5 2.7 4.4 3.0 2.1 -2.2 6.7 7.5

 | 4.5 4.2 4.3 3.3 2.1 -2.2 5.7
3.5 2.7 4.4 3.0 2.1 -2.2 6.7

 | 4.5 4.2 4.3 3.3 2.1 -2.2 5.7 6.1
 | 4.5 4.2 4.3 3.3 2.1 -2.2 5.7 6.1 5.3

 |
 |
 | 3.5 3.1 7.4
 | 9.5
 | 6.2 5.0
 |
 | 4.3 4.0 3.8 3.5 2.0 -1.8 4.8 5.9 3.2 | 10.0 10.7 3.8 3.1 2.0 -1.8 4.2 5.8 4.7 | 5.7 2.9 4.1 3.2 2.3 -1.8 9.8 6.0 6.9
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 | 40 45 44 25 2.4 5.0 5.0 4.0 4.0 4.0 4.0 4.0 4.0 4.0 4.0 4.0 4

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 | 26 27 11 20 21 22 24

 | 4.5 4.5 5.3 2.1 -2.2 5.7 6.1 5.3
 | 01 T1 00 T0 CC CT UT
 |
 | 2.2 3.5 3.1 7.4 5.3
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 | 4.3 4.0 10.7 3.8 3.1 2.0 -1.8 4.2 5.8 4.0 4.1 4.0 3.0 2.5 -1.5 4.8 5.9 4.0 4.1 4.0 3.0 2.5 -1.5 4.6 4.6 5.0 5.7 4.3 3.8 2.8 -1.5 4.4 5.2 5.0 5.7 2.8 2.1 -3.6 6.0 4.3 6.0 5.6 5.9 3.4 1.8 -4.1 5.6 6.4 5.0 5.5 5.7 2.8 1.9 -2.0 3.9 2.9 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.3 3.7 4.6 4.5 5.3 2.1 -2.4 5.2 5.6 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.3 2.3 4.2 4.5 5.3 2.1 -2.4 5.2 5.6 2.3 4.2 4.3 3.3 2.1 -2.2 5.7 <td>4.3 4.0 3.8 3.1 2.0 -1.8 4.2 4.0 4.1 4.0 3.0 2.5 -1.5 4.8 4.0 4.1 4.0 3.0 2.5 -1.5 4.4 5.0 5.7 4.3 3.8 2.8 -1.5 4.4 5.7 5.5 5.7 2.8 2.1 -3.6 6.0 6.0 5.6 5.9 3.4 1.8 -4.1 5.6 6.0 5.6 5.9 3.4 1.8 -4.1 5.6 6.0 5.6 5.9 3.4 1.8 -4.1 5.6 6.0 5.6 5.9 3.4 1.8 -4.1 5.6 6.0 5.6 5.9 3.7 -1.4 3.4 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.5 4.2 4.5 5.3 2.1 -2.4 5.2 2.3 4.2 4.5 5.3 2.1 -2.4 5.2 2.2 4.2 4.3<td>4.3 4.0 10.7 3.8 3.1 2.0 -1.8 4.2 5.8 4.0 4.1 4.0 3.0 2.5 -1.5 4.8 5.9 4.0 4.1 4.0 3.0 2.5 -1.5 4.6 4.6 5.0 5.7 4.3 3.8 2.8 -1.5 4.4 5.2 5.0 5.7 2.8 2.1 -3.6 6.0 4.3 6.0 5.6 5.9 3.4 1.8 4.1 5.6 6.4 5.7 5.5 5.7 2.8 1.9 -2.0 3.9 2.9 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.3 3.7 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.3 3.5 4.2 5.3 2.1 -2.4 5.2 5.6 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.3 2.3 4.2 4.5 5.3 2.1 -2.2 5.7</td><td>4.3 4.0 3.8 3.1 2.0 -1.8 4.2 5.8 4.7 4.3 4.0 4.0 3.0 2.5 -1.5 4.8 5.9 3.2 4.0 4.1 4.0 3.0 2.5 -1.5 4.6 4.5 4.6 4.5 5.0 5.7 4.3 3.8 2.8 -1.5 4.4 5.2 3.2 5.0 5.7 4.3 3.8 2.8 -1.5 4.6 4.5 5.5 5.0 5.5 6.0 5.6 5.7 2.8 2.1 -3.6 6.0 4.3 5.2 3.2 6.0 5.6 5.9 3.4 1.8 -4.1 5.6 6.4 3.8 5.2 6.0 5.6 5.9 3.4 1.8 -4.1 5.6 6.4 3.8 3.5 3.6 3.9 2.8 1.9 -2.0 3.9 2.9 3.7 4.0 4.0 4.5 5.3 2.1 -2.4 5.2 5.6 5.6 3.7</td><td>4.3 4.0 3.8 3.1 2.0 -1.8 4.2 5.8
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 | 4.3 4.0 3.8 3.1 2.0 -1.8 4.2 4.0 4.1 4.0 3.0 2.5 -1.5 4.8 4.0 4.1 4.0 3.0 2.5 -1.5 4.4 5.0 5.7 4.3 3.8 2.8 -1.5 4.4 5.7 5.5 5.7 2.8 2.1 -3.6 6.0 6.0 5.6 5.9 3.4 1.8 -4.1 5.6 6.0 5.6 5.9 3.4 1.8 -4.1 5.6 6.0 5.6 5.9 3.4 1.8 -4.1 5.6 6.0 5.6 5.9 3.4 1.8 -4.1 5.6 6.0 5.6 5.9 3.7 -1.4 3.4 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.5 4.2 4.5 5.3 2.1 -2.4 5.2 2.3 4.2 4.5 5.3 2.1 -2.4 5.2 2.2 4.2 4.3 <td>4.3 4.0 10.7 3.8 3.1 2.0 -1.8 4.2 5.8 4.0 4.1 4.0 3.0 2.5 -1.5 4.8 5.9 4.0 4.1 4.0 3.0 2.5 -1.5 4.6 4.6 5.0 5.7 4.3 3.8 2.8 -1.5 4.4 5.2 5.0 5.7 2.8 2.1 -3.6 6.0 4.3 6.0 5.6 5.9 3.4 1.8 4.1 5.6 6.4 5.7 5.5 5.7 2.8 1.9 -2.0 3.9 2.9 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.3 3.7 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.3 3.5 4.2 5.3 2.1 -2.4 5.2 5.6 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.3 2.3 4.2 4.5 5.3 2.1 -2.2 5.7</td> <td>4.3 4.0 3.8 3.1 2.0 -1.8 4.2 5.8 4.7 4.3 4.0 4.0 3.0 2.5 -1.5 4.8 5.9 3.2 4.0 4.1 4.0 3.0 2.5 -1.5 4.6 4.5 4.6 4.5 5.0 5.7 4.3 3.8 2.8 -1.5 4.4 5.2 3.2 5.0 5.7 4.3 3.8 2.8 -1.5 4.6 4.5 5.5 5.0 5.5 6.0 5.6 5.7 2.8 2.1 -3.6 6.0 4.3 5.2 3.2 6.0 5.6 5.9 3.4 1.8 -4.1 5.6 6.4 3.8 5.2 6.0 5.6 5.9 3.4 1.8 -4.1 5.6 6.4 3.8 3.5 3.6 3.9 2.8 1.9 -2.0 3.9 2.9 3.7 4.0 4.0 4.5 5.3 2.1 -2.4 5.2 5.6 5.6 3.7</td> <td>4.3 4.0 3.8 3.1 2.0 -1.8 4.2 5.8 4.7 4.3 4.0 4.0 3.0 2.5 -1.5 4.6 4.5 4.6 4.5 4.0 4.1 4.0 3.0 2.5 -1.5 4.6 4.5 3.2 5.0 5.7 4.3 3.8 2.8 -1.5 4.5 5.0 5.5 5.7 4.3 3.8 2.8 -1.5 4.5 5.0 5.5 6.0 5.6 5.9 3.4 1.8 -4.1 5.6 6.4 3.8 5.7 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.8 3.7 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.3 2.4 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.3 2.4 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.3 2.4 3.5 4.2 3.8 3.7 2.5</td> <td>4.3 4.0 3.8 3.1 2.0 -1.8 4.2 5.8 4.7 4.3 4.0 4.0 3.0 2.5 -1.5 4.6 4.5 4.6 4.5 4.0 4.1 4.0 3.1 1.8 -2.2 4.4 5.2 3.2 5.0 5.7 4.3 3.8 2.8 -1.5 4.5 5.0 5.5 5.7 4.3 3.8 2.8 -1.5 4.5 5.0 5.5 6.0 5.6 5.9 3.4 1.8 4.1 5.6 6.4 3.8 6.0 5.6 5.9 3.4 1.8 4.1 5.6 6.4 3.8 5.7 4.0 4.0 3.1 2.9 2.0 3.9 2.9 3.7 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.3 2.4 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.3 2.4 4.0 4.0 3.1 2.9 2.2 5.6</td> <td>4.3 4.0 3.8 3.1 2.0 -1.8 4.2 5.8 4.7 4.0 4.1 4.0 3.0 2.5 -1.5 4.8 5.9 3.2 4.0 4.1 4.0 3.0 2.5 -1.5 4.6 4.5 4.6 4.5 5.0 5.7 4.3 3.1 1.8 -2.2 4.4 5.2 3.2 5.0 5.7 4.3 3.8 2.8 -1.5 4.5 5.0 5.5 6.0 5.6 5.7 2.8 2.1 -3.6 6.0 4.3 5.2 6.0 5.6 5.9 3.4 1.8 -4.1 5.6 6.4 3.8 6.0 5.6 5.9 3.4 1.8 -4.1 5.6 6.4 3.8 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.3 2.4 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.3 2.4 3.7 4.6 4.5 5.3 2.1</td> <td>4.3 4.0 10.7 3.8 3.1 2.0 -1.8 4.2 5.8 4.7 4.3 4.0 4.0 3.0 2.5 -1.5 4.6 4.5 3.2 4.0 4.1 4.0 3.1 1.8 -2.2 4.4 5.9 3.2 5.0 5.7 4.3 3.8 2.8 -1.5 4.5 5.0 5.5 5.7 5.5 5.7 2.8 2.1 -3.6 6.0 4.3 5.2 6.0 5.6 5.9 3.4 1.8 -4.1 5.6 6.4 3.8 5.7 2.8 1.9 -2.0 3.9 2.9 3.7 4.0 4.0 3.1 2.9 3.9 2.9 3.7 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.3 2.4 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.3 2.4 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.3 2.4</td> <td>4.3 4.0 3.8 3.1 2.0 -1.8 4.2 5.8 4.7 4.3 4.0 4.0 3.0 2.5 -1.5 4.6 4.6 4.5 4.0 4.1 4.0 3.0 2.5 -1.5 4.6
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 4.3 3.8 2.8 -1.5 4.5 5.0 5.7 5.5 5.7 2.8 2.1 -3.6 6.4 5.0 5.7 4.0 3.1 2.8 1.9 -2.0 3.9 2.9 4.0 4.0 3.1 2.8 1.9 -2.0 3.9 2.9 5.7 4.5 5.3 2.8 1.9 -2.0 3.9 2.9 4.0 3.1 2.9 1.7<td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 10.0 3.4 5.8 3.1 2.2 -3.6 7.9 4.0 4.6 3.9 2.3 -2.3 5.7 4.3 4.0 3.8 3.5 2.0 -1.8 4.8 4.0 4.1 4.0 3.0 2.5 -1.5 4.5 5.0 5.7 4.3 3.8 2.8 -1.5 4.4 5.0 5.7 4.3 3.8 2.8 -1.5 4.5 6.0 5.6 5.9 3.4 1.8 4.1 5.6 6.0 5.6 5.9 3.4 1.8 4.1 5.6 6.0 5.6 5.9 3.4 1.8 4.1 5.6 6.0 5.6 5.9 3.4 1.7 -1.4 3.4 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.5 4.2 4.5</td><td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 10.0 9.2 4.6 3.9 2.3 -2.3 5.1 6.4 4.0 10.7 3.8 3.1 2.0 -1.8 4.2 5.8 4.0 4.1 4.0 3.1 2.0 -1.8 4.2 5.8 5.0 4.1 4.0 3.1 2.5 -1.5 4.4 5.9 5.0 5.7 4.3 3.4 1.8 -2.2 4.4 5.2 5.7 5.5 5.7 2.8 2.1 -3.6 6.0 4.3 5.7 5.5 5.7 2.8 2.1 -3.6 6.4 5.0 5.7 5.5 5.7 2.8 1.9 -2.0 3.9 2.9 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.3 3.5 4.5 5.3 2.1 -2.4 5.2 5.6<td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 5.9 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 9.2 4.6 3.9 2.3 -2.3 -2.3 5.1 6.4 5.6 4.0 10.7 3.8 3.1 2.0 -1.8 4.2 5.8 4.7 4.0 4.0 3.8 3.5 2.0 -1.8 4.8 5.9 3.2 4.0 4.1 4.0 3.0 2.5 -1.5 4.6 4.5 5.9 5.0 5.7 4.0 3.1 1.8 -2.2 4.4 5.2 3.2 5.0 5.7 4.3 3.8 2.8 -1.5 4.5 5.0 5.5 5.7 5.5 5.7 2.8 2.1 -3.6 6.0 4.3 3.8 5.7 4.0 4.0 3.1 2.9 3.4 1.8 4.1 5.6 6.4 3.8 5.7 5.5 3.6</td><td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 5.9 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 9.2 4.6 3.9 2.3 -2.3 5.1 6.4 5.6 4.0 10.7 3.8 3.1 2.0 -1.8 4.2 5.8 4.7 4.0 4.1 4.0 3.0 2.5 -1.5 4.8 5.9 3.2 4.0 4.1 4.0 3.1 1.8 -2.2 4.4 5.2 5.5 5.0 5.7 4.3 3.8 2.8 -1.5 4.5 5.0 5.5 5.7 5.5 5.7 2.8 2.1 -3.6 6.0 4.3 5.2 5.7 5.5 5.7 2.8 2.1 -3.6 6.4 3.8 5.7 4.0 3.4 1.8 -4.1 5.6 6.4 3.8 5.7 4.0 3.4 1.8 -4.1 5.6 6.4 3.8<td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 5.9 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 9.2 4.6 3.9 2.3 -2.3 5.1 6.4 5.9 10.0 10.7 3.8 3.1 2.2 -3.8 4.2 5.8 4.7 4.0 4.1 4.0 3.0 2.5 -1.5 4.8 5.9 3.2 4.0 4.1 4.0 3.1 1.8 -2.2 4.4 5.2 3.2 5.0 5.7 4.3 3.8 2.8 -1.5 4.6 4.5 5.0 5.5 5.7 5.5 5.7 2.8 2.1 -3.6 6.0 4.3 3.2 5.7 5.5 5.7 2.8 2.1 -3.6 6.0 4.3 3.8 5.7 4.0 3.1 2.8 2.1 -3.6 6.0 4.3 3.7 5.7 4.5 5.9 3.4 1.8<td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 5.9 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 9.2 4.6 3.9 2.3 -2.3 5.1 6.4 5.9 10.0 10.7 3.8 3.1 2.0 -1.8 4.2 5.8 4.7 4.0 4.1 4.0 3.0 2.0 -1.8 4.8 5.9 3.2 4.0 4.1 4.0 3.0 2.5 -1.5 4.6 4.5 4.6 4.5 5.0 5.7 4.3 3.8 2.8 -1.5 4.4 5.2 3.2 5.7 4.3 3.8 2.8 -1.5 4.4 5.2 3.2 5.7 4.3 3.8 2.8 -1.5 4.5 5.0 5.5 5.7 5.5 5.7 2.8 2.1 -2.2 4.4 5.2 3.2 5.7 4.3 3.4 1.8 -4.5 4.5 5.0<td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 5.9 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 10.7 3.8 3.1 2.3 -2.3 5.1 6.9 2.8 4.3 4.0 4.1 4.0 3.0 2.5 -1.8 4.2 5.8 4.7 4.3 4.0 4.0 3.1 1.8 -2.2 4.4 5.2 5.8 4.5 4.6 4.5 4.6 4.5 5.0 5.5 5.5 5.5 5.7 2.8 -1.5 4.4 5.2 3.2 5.5 5.6 5.6 5.6 5.6 5.6 5.6</td><td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 5.9 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 10.7 3.8 3.1 2.0 -1.8 4.2 5.8 4.7 4.3 4.0 4.0 3.0 2.5 -1.5 4.8 5.9 3.2 4.0 4.1 4.0 3.0 2.5 -1.5 4.5 4.6 4.5 4.3 4.0 4.0 3.1 1.8 -2.2 4.4 5.2 3.2 5.0 5.7 4.3 3.8 2.8 -1.5 4.5 5.0 5.5 5.7 5.5 5.7 2.8 2.1 -3.6 6.4 3.8 5.7 5.5 5.7 2.8 1.9 -2.0 3.9 2.9 3.7 4.0 4.0 3.4 1.8 -4.1 5.6 6.4<td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 5.9 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 10.7 3.8 3.1 2.2 -3.6 7.9 6.9 2.8 4.0 4.0 4.0 3.1 2.0 -1.8 4.2 5.8 4.7 4.3 4.0 4.0 3.0 2.5 -1.5 4.6 4.5 4.5 4.3 4.0 4.0 3.1 1.8 -2.2 4.4 5.2 3.2 5.0 5.7 4.3 3.8 2.8 -1.5 4.6 4.5 5.0 5.5 5.7 5.5 5.7 2.8 2.1 -3.6 6.0 4.3 5.5 6.0 5.6 5.9 3.4 1.8 -4.1 5.6 6.4 3.8 5.7 4.0 4.0 3.4 1.8 -2.2 4.4 5.5 5.0 5.5 6.0 5.6 5.9 3.4</td><td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 5.9 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 9.2 4.6 3.9 2.3 -2.3 5.1 6.4 5.6 10.0 10.7 3.8 3.1 2.0 -1.8 4.2 5.8 4.7</td><td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 5.9 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 9.2 4.6 3.9
2.3 -2.3 5.1 6.4 5.6</td><td>5.7 3.2 4.5 3.6 3.2 -1.3 7.6 10.4 12.0 3.0 2.5 3.8 3.7 2.3 -1.5 9.0 12.3 7.1 3.0 2.5 3.8 3.7 2.2 -1.6 5.0 9.4 7.8 2.3 2.2 4.0 2.4 1.6 -2.4 5.3 5.4 5.3 2.6 1.9 4.0 2.5 2.1 -1.9 5.1 5.8 7.7 2.8 2.4 4.6 2.6 1.8 -2.8 6.4 6.2 6.0</td><td>5.7 2.9 4.1 3.2 2.3 -1.8 9.8 6.0 6.9 5.7 3.2 4.5 3.6 3.2 -1.3 7.6 10.4 12.0 3.0 2.5 3.8 3.7 2.3 -1.5 9.0 12.3 7.1 3.0 2.5 3.8 3.7 2.2 -1.6 5.0 9.4 7.8 2.3 2.2 4.0 2.4 1.6 -2.4 5.3 5.4 5.3 2.6 1.9 4.0 2.5 2.1 -1.9 5.1 5.8 7.7 2.8 2.4 4.6 2.6 1.8 -2.8 6.4 6.2 6.0</td><td>5.7 2.9 4.1 3.2 2.3 -1.8 9.8 6.0 6.9 5.7 3.2 4.5 3.6 3.2 -1.3 7.6 10.4 12.0 3.0 2.5 3.8 3.7 2.3 -1.5 9.0 12.3 7.1 3.0 2.5 3.8 3.7 2.2 -1.6 5.0 9.4 7.8 2.3 2.2 4.0 2.4 1.6 -2.4 5.3 5.4 5.3 2.6 1.9 4.0 2.5 2.1 -1.9 5.1 5.8 7.7 2.8 2.4 4.6 2.6 1.8 -2.8 6.4 6.2 6.0</td><td>Gloss Gloss <th< td=""><td>7/98 2/99 1/98 7/98 2/99 total 1/98 7/98 2/99 1/98 7/98 2/99 test test test delta initial test dest 2/99 2/99 2/99 DFT 60 60 60 60 60 85 85 85 DFT degree deg</td><td>7/98 test 2/99 initial 1/98 test 7/98 test 1/98 test</td></th<></td></td></td></td></td></td></td> | 3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 10.0 9.2 4.6 3.9 2.3 -2.3 7.9 6.9 4.0 10.7 3.8 3.1 2.0 -1.8 4.2 5.8 6.4 4.0 4.1 4.0 3.1 2.0 -1.8 4.8 5.9 6.9 4.0 4.1 4.0 3.1 1.8 -2.2 4.4 5.2 5.6 5.0 5.7 4.3 3.8 2.8 -1.5 4.5 5.0 5.7 5.5 5.7 2.8 2.1 -3.6 6.4 5.0 5.7 4.0 3.1 2.8 1.9 -2.0 3.9 2.9 4.0 4.0 3.1 2.8 1.9 -2.0 3.9 2.9 5.7 4.5 5.3 2.8 1.9 -2.0 3.9 2.9 4.0 3.1 2.9 1.7 <td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 10.0 3.4 5.8 3.1 2.2 -3.6 7.9 4.0 4.6 3.9 2.3 -2.3 5.7 4.3 4.0 3.8 3.5 2.0 -1.8 4.8 4.0 4.1 4.0 3.0 2.5 -1.5 4.5 5.0 5.7 4.3 3.8 2.8 -1.5 4.4 5.0 5.7 4.3 3.8 2.8 -1.5 4.5 6.0 5.6 5.9 3.4 1.8 4.1 5.6 6.0 5.6 5.9 3.4 1.8 4.1 5.6 6.0 5.6 5.9 3.4 1.8 4.1 5.6 6.0 5.6 5.9 3.4 1.7 -1.4 3.4 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.5 4.2 4.5</td> <td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 10.0 9.2 4.6 3.9 2.3 -2.3 5.1 6.4 4.0 10.7 3.8 3.1 2.0 -1.8 4.2 5.8 4.0 4.1 4.0 3.1 2.0 -1.8 4.2 5.8 5.0 4.1 4.0 3.1 2.5 -1.5 4.4 5.9 5.0 5.7 4.3 3.4 1.8 -2.2 4.4 5.2 5.7 5.5 5.7 2.8 2.1 -3.6 6.0 4.3 5.7 5.5 5.7 2.8 2.1 -3.6 6.4 5.0 5.7 5.5 5.7 2.8 1.9 -2.0 3.9 2.9 4.0 4.0 3.1 2.9 1.7 -1.4 3.4 3.3 3.5 4.5 5.3 2.1 -2.4 5.2 5.6<td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 5.9 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 9.2 4.6 3.9 2.3 -2.3 -2.3 5.1 6.4 5.6 4.0 10.7 3.8 3.1 2.0 -1.8 4.2 5.8 4.7 4.0 4.0 3.8 3.5 2.0 -1.8 4.8 5.9 3.2 4.0 4.1 4.0 3.0 2.5 -1.5 4.6 4.5 5.9 5.0 5.7 4.0 3.1 1.8 -2.2 4.4 5.2 3.2 5.0 5.7 4.3 3.8 2.8 -1.5 4.5 5.0 5.5 5.7 5.5 5.7 2.8 2.1 -3.6 6.0 4.3 3.8 5.7 4.0 4.0 3.1 2.9 3.4 1.8 4.1 5.6 6.4 3.8 5.7 5.5 3.6</td><td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 5.9 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 9.2 4.6 3.9 2.3 -2.3 5.1 6.4 5.6 4.0 10.7 3.8 3.1 2.0 -1.8 4.2 5.8 4.7 4.0 4.1 4.0 3.0 2.5 -1.5 4.8 5.9 3.2 4.0 4.1 4.0 3.1 1.8 -2.2 4.4 5.2 5.5 5.0 5.7 4.3 3.8 2.8 -1.5 4.5 5.0 5.5 5.7 5.5 5.7 2.8 2.1 -3.6 6.0 4.3 5.2 5.7 5.5 5.7 2.8 2.1 -3.6 6.4 3.8 5.7 4.0 3.4 1.8 -4.1 5.6 6.4 3.8 5.7 4.0 3.4 1.8 -4.1 5.6 6.4 3.8<td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 5.9 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 9.2 4.6 3.9 2.3 -2.3 5.1 6.4 5.9 10.0 10.7 3.8 3.1 2.2 -3.8 4.2 5.8 4.7 4.0 4.1 4.0 3.0 2.5 -1.5 4.8 5.9 3.2 4.0 4.1 4.0 3.1 1.8 -2.2 4.4 5.2 3.2 5.0 5.7 4.3 3.8 2.8 -1.5 4.6 4.5 5.0 5.5 5.7 5.5 5.7 2.8 2.1 -3.6 6.0 4.3 3.2 5.7 5.5 5.7 2.8 2.1 -3.6 6.0 4.3 3.8 5.7 4.0 3.1 2.8 2.1 -3.6 6.0 4.3 3.7 5.7 4.5 5.9 3.4 1.8<td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 5.9 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 9.2 4.6 3.9 2.3 -2.3 5.1 6.4 5.9 10.0 10.7 3.8 3.1 2.0 -1.8 4.2 5.8 4.7 4.0 4.1 4.0 3.0 2.0 -1.8 4.8 5.9 3.2 4.0 4.1 4.0 3.0 2.5 -1.5 4.6 4.5 4.6 4.5 5.0 5.7 4.3 3.8 2.8 -1.5 4.4 5.2 3.2 5.7 4.3 3.8 2.8 -1.5 4.4 5.2 3.2 5.7 4.3 3.8 2.8 -1.5 4.5 5.0 5.5 5.7 5.5 5.7 2.8 2.1 -2.2 4.4 5.2 3.2 5.7 4.3 3.4 1.8 -4.5 4.5 5.0<td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 5.9 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 10.7 3.8 3.1 2.3 -2.3 5.1
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4.6 2.6 1.8 -2.8 6.4 6.2 6.0</td><td>5.7 2.9 4.1 3.2 2.3 -1.8 9.8 6.0 6.9 5.7 3.2 4.5 3.6 3.2 -1.3 7.6 10.4 12.0 3.0 2.5 3.8 3.7 2.3 -1.5 9.0 12.3 7.1 3.0 2.5 3.8 3.7 2.2 -1.6 5.0 9.4 7.8 2.3 2.2 4.0 2.4 1.6 -2.4 5.3 5.4 5.3 2.6 1.9 4.0 2.5 2.1 -1.9 5.1 5.8 7.7 2.8 2.4 4.6 2.6 1.8 -2.8 6.4 6.2 6.0</td><td>Gloss Gloss <th< td=""><td>7/98 2/99 1/98 7/98 2/99 total 1/98 7/98 2/99 1/98 7/98 2/99 test test test delta initial test dest 2/99 2/99 2/99 DFT 60 60 60 60 60 85 85 85 DFT degree deg</td><td>7/98 test 2/99 initial 1/98 test 7/98 test 1/98 test</td></th<></td></td></td></td> | 3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 5.9 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 9.2 4.6 3.9 2.3 -2.3 5.1 6.4 5.9 10.0 10.7 3.8 3.1 2.2 -3.8 4.2 5.8 4.7 4.0 4.1 4.0 3.0 2.5 -1.5 4.8 5.9 3.2 4.0 4.1 4.0 3.1 1.8 -2.2 4.4 5.2 3.2 5.0 5.7 4.3 3.8 2.8 -1.5 4.6 4.5 5.0 5.5 5.7 5.5 5.7 2.8 2.1 -3.6 6.0 4.3 3.2 5.7 5.5 5.7 2.8 2.1 -3.6 6.0 4.3 3.8 5.7 4.0 3.1 2.8 2.1 -3.6 6.0 4.3 3.7 5.7 4.5 5.9 3.4 1.8 <td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 5.9 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 9.2 4.6 3.9 2.3 -2.3 5.1 6.4 5.9 10.0 10.7 3.8 3.1 2.0 -1.8 4.2 5.8 4.7 4.0 4.1 4.0 3.0 2.0 -1.8 4.8 5.9 3.2 4.0 4.1 4.0 3.0 2.5 -1.5 4.6 4.5 4.6 4.5 5.0 5.7 4.3 3.8 2.8 -1.5 4.4 5.2 3.2 5.7 4.3 3.8 2.8 -1.5 4.4 5.2 3.2 5.7 4.3 3.8 2.8 -1.5 4.5 5.0 5.5 5.7 5.5 5.7 2.8 2.1 -2.2 4.4 5.2 3.2 5.7 4.3 3.4 1.8 -4.5 4.5 5.0<td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 5.9 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 10.7 3.8 3.1 2.3 -2.3 5.1 6.9 2.8 4.3 4.0 4.1 4.0 3.0 2.5 -1.8 4.2 5.8 4.7 4.3 4.0 4.0 3.1 1.8 -2.2 4.4 5.2 5.8 4.5 4.6 4.5 4.6 4.5 5.0 5.5 5.5 5.5 5.7 2.8 -1.5 4.4 5.2 3.2 5.5 5.6 5.6 5.6 5.6 5.6 5.6</td><td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 5.9 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 10.7 3.8 3.1 2.0 -1.8 4.2 5.8 4.7 4.3 4.0 4.0 3.0 2.5 -1.5 4.8 5.9 3.2 4.0 4.1 4.0 3.0 2.5 -1.5 4.5 4.6 4.5 4.3 4.0 4.0 3.1 1.8 -2.2 4.4 5.2 3.2 5.0 5.7 4.3 3.8 2.8 -1.5 4.5 5.0 5.5 5.7 5.5 5.7 2.8 2.1 -3.6 6.4 3.8 5.7 5.5 5.7 2.8 1.9 -2.0 3.9 2.9 3.7 4.0 4.0 3.4 1.8 -4.1 5.6 6.4<td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 5.9 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 10.7 3.8 3.1 2.2 -3.6 7.9 6.9 2.8 4.0 4.0 4.0 3.1 2.0 -1.8 4.2 5.8 4.7 4.3 4.0 4.0 3.0 2.5 -1.5 4.6 4.5 4.5 4.3 4.0 4.0 3.1 1.8 -2.2 4.4 5.2 3.2 5.0 5.7 4.3 3.8 2.8 -1.5 4.6 4.5 5.0 5.5 5.7 5.5 5.7 2.8 2.1 -3.6 6.0 4.3 5.5 6.0 5.6 5.9 3.4 1.8 -4.1 5.6 6.4 3.8 5.7 4.0 4.0 3.4 1.8 -2.2 4.4 5.5 5.0 5.5 6.0 5.6 5.9 3.4</td><td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 5.9 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 9.2 4.6 3.9 2.3 -2.3 5.1 6.4 5.6 10.0 10.7 3.8 3.1 2.0 -1.8 4.2 5.8 4.7</td><td>3.6 3.3 4.7 2.9 1.9 -2.8 5.8 6.4 5.9 4.0 3.4 5.8 3.1 2.2 -3.6 7.9 6.9 2.8 10.0 9.2 4.6 3.9 2.3 -2.3 5.1 6.4 5.6</td><td>5.7 3.2 4.5 3.6 3.2 -1.3 7.6 10.4 12.0 3.0 2.5 3.8 3.7 2.3 -1.5 9.0 12.3 7.1 3.0 2.5 3.8 3.7 2.2 -1.6 5.0 9.4 7.8 2.3 2.2 4.0 2.4 1.6 -2.4 5.3 5.4 5.3 2.6 1.9 4.0 2.5 2.1 -1.9 5.1 5.8 7.7 2.8 2.4 4.6 2.6 1.8 -2.8 6.4 6.2 6.0</td><td>5.7 2.9 4.1 3.2 2.3 -1.8 9.8 6.0 6.9 5.7 3.2 4.5 3.6 3.2 -1.3 7.6 10.4 12.0 3.0 2.5 3.8 3.7 2.3 -1.5 9.0 12.3 7.1 3.0 2.5 3.8 3.7 2.2 -1.6 5.0 9.4 7.8 2.3 2.2 4.0 2.4 1.6 -2.4 5.3 5.4 5.3 2.6 1.9 4.0 2.5 2.1 -1.9 5.1 5.8 7.7 2.8 2.4 4.6 2.6 1.8 -2.8 6.4 6.2 6.0</td><td>5.7 2.9 4.1 3.2 2.3 -1.8 9.8 6.0 6.9 5.7 3.2 4.5 3.6 3.2 -1.3 7.6 10.4 12.0 3.0 2.5 3.8 3.7 2.3 -1.5 9.0 12.3 7.1 3.0 2.5 3.8 3.7 2.2 -1.6 5.0 9.4 7.8 2.3 2.2 4.0 2.4 1.6 -2.4 5.3 5.4 5.3 2.6 1.9 4.0 2.5 2.1 -1.9 5.1 5.8 7.7 2.8 2.4 4.6 2.6 1.8 -2.8 6.4 6.2 6.0</td><td>Gloss Gloss <th< td=""><td>7/98 2/99 1/98 7/98 2/99 total 1/98 7/98 2/99 1/98 7/98 2/99 test test test delta initial test dest 2/99 2/99 2/99 DFT 60 60 60 60 60 85 85 85 DFT degree deg</td><td>7/98 test 2/99 initial
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| 3.0 2.5 3.8 3.7 2.3 -1.3 7.6 10.4 12.0 3.0 2.5 3.8 3.7 2.3 -1.5 9.0 12.3 7.1 3.0 2.5 3.8 3.7 2.2 -1.5 9.0 12.3 7.1 2.6 1.9 4.0 2.5 2.1 1.6 5.0 9.4 5.8 2.7 2.4 4.6 2.6 1.8 -2.6 6.0 9.4 5.8 2.7 2.5 4.4 2.6 1.8 -2.6 6.0 9.4 5.3 4.0 3.4 4.6 2.6 1.8 -2.6 6.0 9.4 5.9 4.0 3.4 5.8 3.1 2.2 3.6 5.7 4.9 6.0
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 | 3.7 4.5 4.5 3.6 3.7 2.3 -1.3 7.6 3.0 2.5 3.8 3.7 2.2 -1.6 5.0 3.0 2.5 3.8 3.7 2.2 -1.6 5.0 2.3 2.2 4.0 2.4 1.6 -1.9 5.1 2.8 2.4 4.6 2.6 1.8 -2.8 6.4 2.7 2.5 4.4 2.6 1.8 -2.6 5.3 3.6 3.3 4.7 2.9 1.9 -2.8 5.8 4.0 3.4 2.6 1.8 -2.6 5.3 4.0 3.4 2.9 1.9 -2.8 5.1 4.0 4.0 3.0 2.3 2.3 2.3 2.4 4.8 4.0 4.1 4.0 3.0 2.8 2.1 4.4 4.6 5.6 5.3 5.7 5.5 5.7 2.8 2.1 2.2 4.4 4.6 4.6 4.6 4.6 4.6 4.6 4.6 4.6

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DFT = Dry Film Thickness

Appendix V

Painted Tinker AFB, May 97, RIGHT SIDE

	-3-	KC-135, Tail No. 64-14838	35, T	ail N	0.64	-148	38		
		Jan-98			Jul-98			Feb-99	·
Location	initial	initial	initial	test	test	test	test	test	test
	ב	ä	b*	<u>.</u>	a,	D*	<u>.</u>	a,	p*
	49.331	-1.368	-3.818	49.254	-1.522	-3.911	51.440	-1.940	-4.260
190	49.316	-1.368	-3.696	48.319	-1.579	-3.692	52.880	-1.940	-4.060
	48.665	-1.347	-3.645	48.614	-1.697	-3.792	51.940	-1.970	-4.330
), t				48.757	-1.582	-3.799	52.100	-1.980	-4.390
shi	49.952	-1.472	-3.931	51.517	-1.859	-4.222	52.300	-1.940	-4.130
	50.018	-1.375	-3.806	51.653	-1.816	-4.386	51.700	-1.880	-4.080
o iyt	49.716	-1.422	-3.812	51.458	-1.810	-4.220	51.940	-1.880	-4 .100
ji 2	49.875	-1.393	-3.758	51.465	-1.846	-4.322	52.720	-1.920	-4.100
11				51.613	-1.866	-4.331	54.260	-2.040	-4.270
RH 14	1 50.157	-1.393	-3.640	50.096	-1.574	-4.158	53.180	-2.100	-4.510
Motors 15	49.895	-1.375	-3.744	49.904	-1.603	-4.240	55.210	-2.290	-4.420
19	49.821	-1.350	-3.648	50.674	-1.692	-4.183	52.730	-2.030	-4.300
-18	3 49.844	-1.353	-3.664	50.673	-1.705	-4.118	53.790	-2.130	-4.550
-14 -14		-1.313	-3.674	50.679	-1.780	-4.288	54.050	-2.080	-4.390
		-1.375	-3.744	50.565	-1.811	-4.337	54.070	-2.090	4.350
esr 12	_	-1.364	-3.628	51.488	-1.882	-4.263	54.220	-2.030	-4.070
13	3 50.157	-1.393	-3.640	51.488	-1.882	-4.263	54.300	-2.060	-4.180
S Put	49.801	-1.363	-3.652	50.960	-1.764	-4.185	54.280	-2.040	-4.350
	49.801	-1.363	-3.652	51.077	-1.789	-4.171	53.280	-2.010	-4.390
23	3 50.198	-1.364	-3.533	51.077	-1.789	-4.171	53.460	-2.080	-4.490
22	49.803	-1.378	-3.573	51.260	-1.775	-4.153	51.550	-1.800	-4.280
Average	49.788	-1.375	-3.698	50.643	-1.746	-4.162	53.114	-2.011	-4.286
Right Wing	49.553	-1.392	-3.781	50.294	-1.731	-4.075	52.364	-1.943	4.191
Right Fuselage	le 49.671	-1.396	-3.755	50.388	-1.737	-4.102	52.558	-1.961	4.219

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Painted Tinker AFB, May 97, RIGHT SIDE

,				K	KC-135,	1	Tail No.	64-14838	4838				
-			7/98-i	/98-initial			2/99.	2/99-7/98			2/99-i	2/99-initial	
Location		delta L*	delta a*	delta b*	delta E*	delta L*	delta a*	delta b*	delta E*	delta L*	delta a*	delta b*	delta E*
	3	-0.077	-0.154	-0.093	0.196	2.186	-0.418	-0.349	2.253	2.109	-0.572	-0.442	1.046
Jac	4	-0.997	-0.211	0.004	1.019	4.561	-0.361	-0.368	4.590	3.564	-0.572	-0.364	1.621
i		-0.051	-0.350	-0.147	0.383	3.326	-0.273	-0.538	3.380	3.275	-0.623	-0.685	1.402
ə ɔ١	ေ					3.343	-0.398	-0.591	3.418				
ini) Shi	_	1.565	-0.387	-0.291	1.638	0.783	-0.081	0.092	0.793	2.348	-0.468	-0.199	1.297
ns		1.635	-0.441	-0.580	1.790	0.047	-0.064	0.306	0.316	1.682	-0.505	-0.274	0.950
		1.742	-0.388	-0.408	1.831	0.482	-0.070	0.120	0.502	2.224	-0.458	-0.288	1.216
·	9	1.590	-0.453	-0.564	1.747	1.255	-0.074	0.222	1.277	2.845	-0.527	-0.342	1.408
_						2.647	-0.174	0.061	2.653				
		-0.061	-0.181	-0.518	0.552	3.084	-0.526	-0.352	3.148	3.023	-0.707	-0.870	1.202
Motors 1	15	0.009	-0.228	-0.496	0.546	5.306	-0.687	-0.180	5.353	5.315	-0.915	-0.676	1.930
	6	0.853	-0.342	-0.535	1.063	2.056	-0.338	-0.117	2.087	2.909	-0.680	-0.652	1.256
·	<u></u>	0.829	-0.352	-0.454	1.009	3.117	-0.425	-0.432	3.175	3.946	-0.777	-0.886	1.511
•		0.835	-0.467	-0.614	1.137	3.371	-0.300	-0.102	3.386	4.206	-0.767	-0.716	1.650
•-		0.670	-0.436	-0.593	0.995	3.505	-0.279	-0.013	3.516	4.175	-0.715	-0.606	1.689
esn	2	1.604	-0.518	-0.635	1.801	2.732	-0.148	0.193	2.743	4.336	-0.666	-0.442	1.797
•		1.331	-0.489	-0.623	1.549	2.812	-0.178	0.083	2.819	4.143	-0.667	-0.540	1.713
	_	1.159	-0.401	-0.533	1.337	3.320	-0.276	-0.165	3.336	4.479	-0.677	-0.698	1.762
		1.276	-0.428	-0.519	1.442	2.203	-0.221	-0.219	2.225	3.479	-0.647	-0.738	1.447
N	23	0.879	-0.425	-0.638	1.166	2.383	-0.291	-0.319	2.422	3.262	-0.716	-0.957	1.261
		1.457	-0.397	-0.580	1.618	0.290	-0.025	-0.127	0.318	1.747	-0.422	-0.707	0.786
Average		0.855	-0.371	-0.464	1.201	2.515	-0.267	-0.133	2.558	3.319	-0.636	-0.583	1.418
Right Wing		0.772	-0.341	-0.297	1.229	2.070	-0.213	-0.116	2.131	2.578	-0.532	-0.371	1.277
Right Fuselage		1.089	-0.425	-0.572	1.312	2.579	-0.248	-0.122	2.603	3.668	-0.673	-0.694	1.487

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Painted Tinker AFB, May 97, LEFT SIDE

		KC-	KC-135, Tail No. 64-14838	rail N	0. 64	-1483	82		
	·	Jan-98			Jui-98			Feb-99	
Location	initial	initial	initial h*	test	test	test h*	test	test	test
	,	5	2	1	5	2	1	đ	2
43	48.803	-1.456	-3.990	49.037	-1.680	-4.018	50.480	-1.840	-4.120
•	48.710	-1.433	-3.823	48.649	-1.581	-3.858	52.110	-2.040	-4.390
pe 45	47.816	-1.398	-3.671	49.126	-1.705	-4.159	52.170	-2.010	-4.380
9:	48.289	-1.299	-3.432	48.916	-1.632	-4.046	50.410	-1.810	-4.060
9, iac iac	49.930	-1.459	-3.995	51.774	-1.856	-4.429	51.680	-1.880	-4.030
μn	50.312	-1.452	-4.051	51.997	-1.981	-4.229	52.690	-1.950	-4.120
S	50.048	-1.435	-4.012	51.614	-1.839	-4.340	53.350	-1.990	4.140
	50.187	-1.443	-3.916	51.919	-1.872	-4.420	52.290	-1.850	-4.200
98 1	50.187	-1.443	-3.916	51.210	-1.822	-4.404	52.220	-1.890	-4.240
35	50.125	-1.410	-3.797	51.214	-1.779	-4.397	53.800	-2.040	-4.260
ŀ	49.439	-1.335	-3.675	49.435	-1.533	-4.161	55.210	-2.290	-4.420
Motors 50	49.502	-1.314	-3.668	49.672	-1.632	-4.297	51.760	-1.970	-4.550
32	50.100	-1.358	-3.777	50.491	-1.677	-4.288	52.190	-1.960	-4.460
34	50.026	-1.350	-3.738	50.642	-1.742	-4.287	51.860	-1.980	4.360
34	49.845	-1.342	-3.719	51.064	-1.849	-4.378	52.670	-1.950	-4.430
	49.945	-1.347	-3.639	50.817	-1.783	-4.226	51.620	-1.910	-4.440
	49.865	-1.370	-3.684	51.241	-1.789	-4.177	54.870	-2.210	-4.510
9s 4	49.690	-1.387	-3.768	51,354	-1,780	-4.151	53.820	-2.170	-4.520
	49.759	-1.401	-3.753	51.574	-1.920	-4.469	50.510	-1.950	-4.260
	49.669	-1.350	-3.649	51.227	-1.882	-4.397	52.430	-1.980	-4.500
	49.481	-1.313	-3.633	51.015	-1.814	-4.345	53.440	-2.160	-4.550
27	49.458	-1.338	-3.725	50.743	-1.790	-4.377	54.070	-2.220	-4.630
47	49.439	-1.335	-3.675	46.427	-1.275	-3.105			
48	49.502	-1.314	-3.668	47.848	-1.296	-3.301			
Average	49.589	-1.378	-3.766	50.375	-1.730	-4.177	52.530	-2.002	-4,344
Left Wing	49.441	-1.423	-3.860	50.546	-1.775	-4.230	52.120	-1.930	-4.194
Left Fuselage	49.732	-1.350	-3.702	50.370	-1.716	-4.125	52.748	-2.049	-4.466

Appendix V

Painted Tinker AFB, May 97, LEFT SIDE

Committee Comm					ス	KC-135,	5, Tail	S S	64-14838	1838				
On L* a* b* e* L* a* b* b* e* L* b* b* e* L* a* b* b* e* L* a* b* e* L* a* b* e* L* a* b* e* L* a* b* b* e* L* a* b* b* e* L* a* b* b*<		-		1/98/L	nitial			2/99.	7/98			799-	nitial	
43 0.234 -0.224 -0.024 -0.026 0.325 1.43 -0.160 -0.102 1.455 1.677 -0.334 -0.130 44 -0.061 -0.146 -0.035 0.164 -0.365 0.221 3.667 4.354 -0.130 -0.068 45 1.310 -0.307 -0.488 1.431 3.044 -0.305 -0.221 3.067 4.354 -0.169 -0.709 40 1.310 -0.307 -0.488 1.494 -0.014 1.505 -0.421 -0.069 -0.014 1.505 -0.171 -0.014 -0.069 -0.014 1.506 -0.014 -0.015 -0.014 -0.015 -0.014 -0.015 -0.014 -0.016 -0.014 -0.016 -0.014 -0.016 -0.016 -0.016 -0.016 -0.014 -0.016 -0.016 -0.014 -0.016 -0.017 -0.014 -0.024 -0.014 -0.016 -0.017 -0.014 -0.024 -0.014 -0.024 -0.014 -0.024 <th>Locati</th> <th>ion</th> <th>deita *</th> <th>delta a*</th> <th>delta b*</th> <th>delta F*</th> <th>delta</th> <th>delta</th> <th>delta b*</th> <th>delta</th> <th>delta</th> <th>deita</th> <th>delta</th> <th>delta</th>	Locati	ion	deita *	delta a*	delta b*	delta F*	delta	delta	delta b*	delta	delta	deita	delta	delta
44 -0.061 -0.148 -0.035 0.164 3.461 -0.459 -0.532 3.522 3.400 -0.067 -0.567 45 1.310 -0.307 -0.488 1.431 3.044 -0.305 -0.521 3.607 4.354 -0.617 -0.709 46 1.310 -0.307 -0.488 1.484 -0.395 -0.421 1.099 0.702 2.217 3.607 -0.421 -0.094 39 1.685 -0.529 -0.178 1.775 0.094 -0.024 0.399 0.0421 1.750 -0.429 -0.094 31 1.686 -0.404 -0.328 0.054 1.092 0.072 2.378 -0.429 -0.094 31 1.685 -0.529 -0.178 1.736 -0.151 0.702 2.378 -0.489 0.089 31 1.689 -0.609 1.702 0.702 0.702 2.378 -0.489 0.089 4.084 1.986 1.786 0.751		43	0.234	-0.224	-0.028	0.325	1 443	-0 160	-0.102	1 455	1 677	-0.284	-0 130	1 725
45 1.310 -0.307 -0.488 1.431 3.044 -0.305 -0.221 3.064 4.354 -0.014 -0.014 1.505 2.121 -0.511 -0.008 46 0.687 -0.333 -0.614 0.939 1.494 -0.178 -0.014 1.505 2.121 -0.511 -0.628 39 1.685 -0.529 -0.178 1.736 -0.034 0.034 0.019 0.702 2.218 -0.648 -0.049 31 1.566 -0.404 -0.328 1.660 1.736 -0.151 0.200 1.754 2.302 -0.555 -0.128 31 1.566 -0.404 -0.328 1.660 0.751 0.020 0.432 2.03 -0.488 0.604 0.021 0.720 0.432 0.049 0.021 0.720 0.432 0.040 0.028 0.041 0.722 0.432 0.040 0.028 0.041 0.029 0.041 0.040 0.028 0.041 0.029 0.04	<u>ر</u>	44	-0.061	-0.148	-0.035	0.164	3.461	-0.459	-0.532	3.532	3.400	-0.607	-0.567	3.500
46 0.627 -0.333 -0.614 0.939 1.494 -0.178 -0.014 1.505 2.121 -0.511 -0.628 40 1.844 -0.337 -0.434 1.936 -0.094 -0.024 0.399 0.411 1.750 -0.421 -0.035 39 1.686 -0.529 -0.178 1.776 0.022 0.237 0.040 -0.526 -0.159 0.043 0.032 -0.555 -0.038 31 1.686 -0.404 -0.328 1.031 0.040 0.326 0.040 0.032 0.040 0.052 0.040 0.052 0.040 0.052 0.040 0.052 0.040 0.052 0.040 0.052 0.040 0.052 0.040 0.052 0.040 0.052 0.040 0.052 0.040 0.052 0.040 0.052 0.040 0.052 0.040 0.052 0.040 0.052 0.040 0.052 0.040 0.052 0.040 0.052 0.040 0.052 0.0	əd	45	1.310	-0.307	-0.488	1.431	3.044	-0.305	-0.221	3.067	4.354	-0.612	-0.709	4.454
40 1.844 -0.397 -0.434 1.936 -0.094 -0.024 0.399 0.411 1.750 -0.421 -0.035 39 1.685 -0.529 -0.178 1.775 0.693 0.031 0.109 0.702 2.378 -0.498 -0.069 37 1.686 -0.404 -0.328 1.650 -0.429 -0.504 1.736 -0.151 2.000 -0.435 -0.696 -0.151 0.200 1.742 2.032 -0.154 2.035 -0.104 -0.284 -0.156 -0.157 0.200 1.742 2.032 -0.174 1.032 -0.504 -0.0504 -0.068 0.164 1.025 2.032 -0.477 -0.284 -0.069 0.147 -0.284 -0.069 -0.069 -0.069 -0.069 -0.069 -0.069 -0.069 -0.071 -0.284 -0.069 -0.069 -0.071 -0.069 -0.069 -0.069 -0.069 -0.069 -0.069 -0.069 -0.069 -0.069 -0.069 -0.069 </th <th></th> <th>46</th> <th>0.627</th> <th>-0.333</th> <th>-0.614</th> <th>0.939</th> <th>1.494</th> <th>-0.178</th> <th>-0.014</th> <th>1.505</th> <th>2.121</th> <th>-0.511</th> <th>-0.628</th> <th>2.270</th>		46	0.627	-0.333	-0.614	0.939	1.494	-0.178	-0.014	1.505	2.121	-0.511	-0.628	2.270
39 1.685 -0.529 -0.178 1.775 0.693 0.031 0.109 0.702 2.378 -0.498 -0.069 38 1.586 -0.404 -0.328 1.665 -0.404 -0.328 1.666 -0.404 -0.328 1.666 -0.404 -0.328 1.666 -0.404 -0.328 1.660 1.736 -0.429 -0.629 -0.404 -0.555 -0.128 -0.669 1.737 -0.629 -0.607 1.737 -0.697 -0.655 -0.128 -0.609 -0.688 0.689 -0.608 0.164 -0.592 -0.699 -0.669 -0.699 -0.699 -0.699 -0.699 -0.699 -0.699 -0.699 -0.767 -0.259 -0.598 -0.767 -0.259 -0.598 -0.767 -0.259 -0.899 -0.699 -0.699 -0.699 -0.699 -0.699 -0.699 -0.699 -0.699 -0.699 -0.699 -0.699 -0.699 -0.699 -0.699 -0.699 -0.699 -0.699 -0.699		9	1.844	-0.397	-0.434	1.936	-0.094	-0.024	0.399	0.411	1.750	-0.421	-0.035	1.800
38 1,566 -0.404 -0.328 1,650 -0.151 0.200 1,754 3.302 -0.555 -0.128 37 1,732 -0.429 -0.504 1,854 0.371 0.022 0.220 0.432 -0.607 -0.584 36 1,023 -0.429 -0.609 1,195 -0.068 0.164 1.025 2.033 -0.477 -0.894 49 -0.004 -0.188 -0.629 0.725 2.787 -0.259 2.893 -0.777 -0.895 -0.685 -0.486 50 0.170 -0.318 -0.629 0.725 2.787 -0.259 5.895 -0.666 -0.885 -0.486 50 0.170 -0.170 -0.319 -0.511 0.718 -0.289 -0.669 -0.669 -0.669 -0.689 -0.689 -0.689 -0.689 -0.699 -0.699 -0.699 -0.629 0.725 -0.781 -0.289 -0.699 -0.699 -0.629 0.727 -0.781 -0.289		39	1.685	-0.529	-0.178	1.775	0.693	0.031	0.109	0.702	2.378	-0.498	-0.069	2.431
37 1.732 -0.429 -0.504 1.854 0.371 0.022 0.220 0.432 2.103 -0.407 -0.284 36 1.023 -0.379 -0.488 1.195 1.010 -0.088 0.164 1.025 2.033 -0.447 -0.324 36 1.089 -0.369 -0.600 1.286 -0.0751 0.137 2.603 3.675 -0.467 -0.324 49 -0.004 -0.198 -0.486 0.525 2.775 -0.269 0.725 -0.699 -0.787 -0.269 -0.753 2.130 2.258 -0.682 -0.785 -0.765 -0.682 -0.783 -0.072 2.130 2.258 -0.682 -0.783 -0.783 -0.682 -0.783 -0.782 -0.682 -0.783 -0.782 -0.682 -0.783 -0.783 -0.682 -0.783 -0.783 -0.682 -0.783 -0.772 -0.783 -0.783 -0.783 -0.682 -0.783 -0.783 -0.682 -0.783 -0.783		38	1.566	-0.404	-0.328	1.650	1.736	-0.151	0.200	1.754	3.302	-0.555	-0.128	3.351
36 1.023 -0.379 -0.488 1.195 1.010 -0.068 0.164 1.025 2.033 -0.447 -0.324 35 1.089 -0.369 -0.600 1.297 2.586 -0.261 0.137 2.603 3.675 -0.630 -0.463 49 -0.004 -0.198 -0.629 0.725 5.775 -0.757 -0.259 5.830 5.771 -0.955 -0.745 50 0.170 -0.318 -0.629 0.725 2.088 -0.233 2.130 2.258 -0.665 -0.882 31 0.616 -0.392 -0.549 0.718 1.689 -0.238 -0.731 1.288 -0.659 -0.659 -0.747 -0.731 1.289 -0.665 -0.883 -0.712 1.731 2.286 -0.063 -0.669 -0.711 -0.052 1.610 -0.010 -0.053 1.610 -0.653 -0.711 -0.052 1.610 -0.650 -0.663 -0.663 -0.663 -0.663 -0.663	J97	37	1.732	-0.429	-0.504	1.854	0.371	0.022	0.220	0.432	2.103	-0.407	-0.284	2.161
35 1.089 -0.389 -0.600 1.297 2.586 -0.261 0.137 2.603 3.675 -0.463 -0.463 49 -0.004 -0.188 -0.486 0.525 5.775 -0.757 -0.259 5.830 5.771 -0.955 -0.745 50 -0.004 -0.188 -0.629 0.725 2.088 -0.283 -0.172 1.731 2.258 -0.656 -0.882 31 0.616 -0.514 0.718 1.699 -0.283 -0.172 1.731 2.089 -0.652 -0.683 -0.172 0.773 1.243 -0.602 -0.683 31 0.616 -0.507 -0.659 1.476 1.606 -0.101 -0.052 1.610 2.825 -0.683 -0.711 32 0.872 -0.436 -0.587 1.476 1.606 -0.107 -0.214 0.841 -0.690 -0.602 -0.683 -0.714 -0.841 1.875 -0.841 -0.724 0.841 -0.841	1	36	1.023	-0.379	-0.488	1.195	1.010	-0.068	0.164	1.025	2.033	-0.447	-0.324	2.107
49 -0.004 -0.198 -0.486 0.525 5.775 -0.259 5.830 5.771 -0.955 -0.745 50 0.170 -0.318 -0.629 0.725 2.088 -0.233 -0.253 2.130 2.258 -0.656 -0.882 31 0.616 -0.392 -0.549 0.914 1.218 -0.238 -0.073 1.243 1.834 -0.602 -0.652 34 1.219 -0.507 -0.659 1.476 1.606 -0.101 -0.052 1.610 2.285 -0.608 -0.711 33 0.872 -0.436 -0.587 1.476 1.606 -0.107 -0.214 0.841 1.634 -0.630 -0.714 41.219 -0.587 1.138 0.803 -0.127 -0.214 0.841 1.675 -0.608 -0.717 41.376 -0.493 1.521 3.629 -0.421 -0.333 3.688 5.005 -0.840 -0.842 1.844 -0.593 <td< th=""><th></th><th>35</th><th>1.089</th><th>-0.369</th><th>-0.600</th><th>1.297</th><th>2.586</th><th>-0.261</th><th>0.137</th><th>2.603</th><th>3.675</th><th>-0.830</th><th>-0.463</th><th>3.757</th></td<>		35	1.089	-0.369	-0.600	1.297	2.586	-0.261	0.137	2.603	3.675	-0.830	-0.463	3.757
50 0.170 -0.318 -0.629 0.725 2.088 -0.253 -0.253 2.130 2.258 -0.656 -0.882 32 0.391 -0.319 -0.511 0.718 1.699 -0.283 -0.172 1.731 2.090 -0.662 -0.683 34 1.219 -0.507 -0.659 1.476 1.218 -0.238 -0.073 1.243 -0.630 -0.650 34 1.219 -0.507 -0.659 1.476 1.606 -0.101 -0.052 1.610 2.825 -0.608 -0.711 42 1.219 -0.507 -0.659 1.476 1.606 -0.101 -0.052 1.610 2.825 -0.608 -0.711 41 1.218 -0.657 1.666 -0.107 -0.214 0.841 1.875 -0.608 -0.711 41 1.664 -0.390 -0.390 -0.390 -0.390 2.524 4.130 -0.783 -0.608 41 1.654 -0.519 <th>5</th> <th>49</th> <th>-0.004</th> <th>-0.198</th> <th>-0.486</th> <th>0.525</th> <th>5.775</th> <th>-0.757</th> <th>-0.259</th> <th>5.830</th> <th>5.771</th> <th>-0.955</th> <th>-0.745</th> <th>5.897</th>	5	49	-0.004	-0.198	-0.486	0.525	5.775	-0.757	-0.259	5.830	5.771	-0.955	-0.745	5.897
32 0.391 -0.319 -0.511 0.718 1.699 -0.283 -0.172 1.731 2.090 -0.602 -0.683 31 0.616 -0.392 -0.549 0.914 1.218 -0.238 -0.073 1.243 1.834 -0.630 -0.622 34 1.219 -0.507 -0.659 1.476 1.606 -0.101 -0.052 1.610 2.825 -0.608 -0.711 42 1.219 -0.507 -0.659 1.476 1.606 -0.107 -0.214 0.841 1.875 -0.608 -0.711 42 1.376 -0.433 1.521 3.629 -0.214 0.841 1.675 -0.583 -0.716 0.939 -0.254 4.130 -0.840 -0.826 41 1.664 -0.393 -0.383 1.752 2.466 -0.390 -0.369 2.524 4.130 -0.783 -0.762 29 1.558 -0.519 -0.748 1.808 1.242 -0.269 1.24	Motors	50	0.170	-0.318	-0.629	0.725	2.088	-0.338	-0.253	2.130	2.258	-0.656	-0.882	2.511
31 0.616 -0.392 -0.549 0.914 1.218 -0.238 -0.073 1.243 -0.630 -0.622 34 1.219 -0.507 -0.659 1.476 1.606 -0.101 -0.052 1.610 2.825 -0.608 -0.711 33 0.872 -0.436 -0.587 1.138 0.803 -0.127 -0.214 0.841 1.675 -0.563 -0.801 42 1.376 -0.419 -0.493 1.521 3.629 -0.421 -0.313 3.668 5.005 -0.840 -0.828 41 1.664 -0.393 -0.421 -0.333 3.668 5.005 -0.840 -0.828 30 1.815 -0.519 -0.716 2.019 -0.106 -0.030 0.209 1.085 0.751 -0.549 -0.552 31 1.558 -0.512 -0.743 -0.205 2.426 -0.306 -0.205 2.544 4.612 -0.549 -0.579 28 1.534 <th></th> <th>32</th> <th>0.391</th> <th>-0.319</th> <th>-0.511</th> <th>0.718</th> <th>1.699</th> <th>-0.283</th> <th>-0.172</th> <th>1.731</th> <th>2.090</th> <th>-0.602</th> <th>-0.683</th> <th>2.280</th>		32	0.391	-0.319	-0.511	0.718	1.699	-0.283	-0.172	1.731	2.090	-0.602	-0.683	2.280
34 1.219 -0.507 -0.659 1.476 1.606 -0.101 -0.052 1.610 2.825 -0.608 -0.711 33 0.872 -0.436 -0.587 1.138 0.803 -0.127 -0.214 0.841 1.675 -0.563 -0.801 42 1.376 -0.419 -0.493 1.521 3.629 -0.421 -0.333 3.668 5.005 -0.840 -0.826 41 1.664 -0.393 -0.421 -0.333 3.668 5.005 -0.840 -0.826 30 1.815 -0.519 -0.746 -0.390 -0.369 2.524 4.130 -0.783 -0.752 29 1.815 -0.519 -1.064 -0.030 0.209 1.085 2.458 -0.549 -0.549 28 1.534 -0.501 -0.712 1.764 2.436 -0.253 3.859 -0.847 -0.917 27 1.285 -0.450 -0.539 -0.253 3.364 4.612 <th></th> <th>31</th> <th>0.616</th> <th>-0.392</th> <th>-0.549</th> <th>0.914</th> <th>1.218</th> <th>-0.238</th> <th>-0.073</th> <th>1.243</th> <th>1.834</th> <th>-0.630</th> <th>-0.622</th> <th>2.037</th>		31	0.616	-0.392	-0.549	0.914	1.218	-0.238	-0.073	1.243	1.834	-0.630	-0.622	2.037
33 0.872 -0.436 -0.587 1.138 0.803 -0.127 -0.214 0.841 1.675 -0.563 -0.801 42 1.376 -0.419 -0.493 1.521 3.629 -0.421 -0.333 3.668 5.005 -0.840 -0.826 41 1.664 -0.393 -0.383 1.752 2.466 -0.390 -0.369 2.524 4.130 -0.783 -0.752 30 1.815 -0.519 -0.716 2.019 -1.064 -0.390 0.209 1.085 0.751 -0.783 -0.752 29 1.558 -0.532 -0.748 1.808 -0.103 1.211 2.761 -0.630 -0.847 -0.917 27 1.285 -0.452 -0.652 1.510 3.327 -0.430 -0.253 3.364 4.612 -0.862 -0.905 47 -1.654 0.018 0.367 1.694 -0.232 -0.205 2.930 -0.862 -0.905 48		34	1.219	-0.507	-0.659	1.476	1.606	-0.101	-0.052	1.610	2.825	-0.608	-0.711	2.976
42 1.376 -0.419 -0.483 1.521 3.629 -0.421 -0.333 3.668 5.005 -0.840 -0.826 41 1.664 -0.393 1.752 2.466 -0.390 -0.369 2.524 4.130 -0.783 -0.752 30 1.815 -0.519 -0.716 2.019 -1.064 -0.030 0.209 1.085 0.751 -0.783 -0.752 29 1.815 -0.519 -0.716 2.019 -1.064 -0.039 -0.209 1.085 0.751 -0.549 -0.507 29 1.510 -0.712 1.764 2.425 -0.205 2.458 3.859 -0.847 -0.917 27 1.285 -0.652 1.510 3.327 -0.205 2.458 3.859 -0.847 -0.905 47 -3.012 0.060 0.570 3.066 3.327 -0.430 -0.253 3.364 4.612 -0.882 -0.905 4.654 0.018 0.367	ə	33	0.872	-0.436	-0.587	1.138	0.803	-0.127	-0.214	0.841	1.675	-0.563	-0.801	1.940
41 1.664 -0.383 -0.383 1.752 2.466 -0.390 -0.369 2.524 4.130 -0.783 -0.752 30 1.815 -0.519 -0.716 2.019 -1.064 -0.030 0.209 1.085 0.751 -0.549 -0.507 29 1.558 -0.532 -0.748 1.808 1.203 -0.098 -0.103 1.211 2.761 -0.630 -0.851 28 1.534 -0.501 -0.712 1.764 -0.098 -0.103 1.211 2.761 -0.630 -0.851 27 1.534 -0.501 -0.712 1.764 -0.236 -0.205 2.458 3.959 -0.847 -0.917 27 1.285 -0.452 -0.652 1.510 3.327 -0.430 -0.253 3.364 4.612 -0.882 -0.905 48 -1.654 0.018 0.367 1.694 1.860 -0.232 -0.078 2.078 2.679 -0.519 -0.534 <	ge)	42	1.376	-0.419	-0.493	1.521	3.629	-0.421	-0.333	3.668	5.005	-0.840	-0.826	5.142
30 1.815 -0.519 -0.716 2.019 -1.064 -0.030 0.209 1.085 0.751 -0.549 -0.507 29 1.558 -0.532 -0.748 1.808 1.203 -0.098 -0.103 1.211 2.761 -0.630 -0.851 28 1.558 -0.501 -0.712 1.764 2.425 -0.346 -0.205 2.458 3.959 -0.847 -0.851 27 1.285 -0.452 -0.652 1.510 3.327 -0.430 -0.253 3.364 4.612 -0.882 -0.905 48 -1.654 0.018 0.367 1.694 -0.232 -0.078 2.008 2.930 -0.619 -0.570 0.787 -0.351 -0.412 1.383 1.860 -0.232 -0.078 2.008 2.679 -0.619 -0.570 1.105 -0.352 -0.370 1.257 1.574 -0.157 1.974 2.964 -0.693 -0.758	əs	4	1.664	-0.393	-0.383	1.752	2.466	-0.390	-0.369	2.524	4.130	-0.783	-0.752	4.270
29 1.558 -0.532 -0.748 1.808 1.203 -0.098 -0.103 1.211 2.761 -0.630 -0.851 28 1.534 -0.501 -0.712 1.764 2.425 -0.346 -0.205 2.458 3.959 -0.847 -0.917 27 1.285 -0.452 -0.652 1.510 3.327 -0.430 -0.253 3.364 4.612 -0.862 -0.905 48 -1.654 0.018 0.367 1.694 -0.232 -0.078 2.008 2.930 -0.619 -0.570 1.105 -0.352 -0.370 1.257 1.574 -0.155 0.036 1.649 2.679 -0.507 -0.334 age 0.639 -0.366 -0.423 1.615 1.731 -0.246 -0.157 1.974 2.964 -0.693 -0.758	n-i	30	1.815	-0.519	-0.716	2.019	-1.064	-0.030	0.209	1.085	0.751	-0.549	-0.507	1.059
28 1.534 -0.501 -0.712 1.764 2.425 -0.346 -0.205 2.458 3.959 -0.847 -0.917 27 1.285 -0.452 -0.652 1.510 3.327 -0.430 -0.253 3.364 4.612 -0.862 -0.905 47 -3.012 0.060 0.570 3.066 -0.430 -0.253 3.364 4.612 -0.862 -0.905 48 -1.654 0.018 0.367 1.694 -0.232 -0.078 2.008 2.930 -0.619 -0.570 0.787 -0.352 -0.370 1.257 1.574 -0.155 0.036 1.649 2.679 -0.507 -0.334 3ge 0.639 -0.423 1.615 1.731 -0.246 -0.157 1.974 2.964 -0.693 -0.758	ħ	29	1.558	-0.532	-0.748	1.808	1.203	-0.098	-0.103	1.211	2.761	-0.630	-0.851	2.957
27 1.285 -0.452 -0.652 1.510 3.327 -0.430 -0.253 3.364 4.612 -0.882 -0.905 48 -3.012 0.060 0.570 3.066 3.327 -0.430 -0.253 3.364 4.612 -0.882 -0.905 48 -1.654 0.018 0.367 1.694 1.694 2.008 2.930 -0.619 -0.570 0.787 -0.352 -0.370 1.257 1.574 -0.155 0.036 1.649 2.679 -0.507 -0.334 age 0.639 -0.366 -0.423 1.615 1.731 -0.246 -0.157 1.974 2.964 -0.693 -0.758) 	28	1.534	-0.501	-0.712	1.764	2.425	-0.346	-0.205	2.458	3.959	-0.847	-0.917	4.151
47 -3.012 0.060 0.570 3.066 48 -1.654 0.018 0.367 1.694 0.787 -0.351 -0.412 1.383 1.860 -0.232 -0.078 2.008 2.930 -0.619 -0.570 1.105 -0.352 -0.370 1.257 1.574 -0.155 0.036 1.649 2.679 -0.507 -0.334 age 0.639 -0.366 -0.423 1.615 1.731 -0.246 -0.157 1.974 2.964 -0.693 -0.758		27	1.285	-0.452	-0.652	1.510	3.327	-0.430	-0.253	3.364	4.612	-0.882	-0.905	4.782
48 -1.654 0.018 0.367 1.694 0.787 -0.351 -0.412 1.383 1.860 -0.232 -0.078 2.008 2.930 -0.619 -0.570 0.787 -0.352 -0.370 1.257 1.574 -0.155 0.036 1.649 2.679 -0.507 -0.334 0.639 -0.366 -0.423 1.615 1.731 -0.246 -0.157 1.974 2.964 -0.693 -0.758		47	-3.012	0.060	0.570	3.066								
0.787 -0.351 -0.412 1.383 1.860 -0.232 -0.078 2.008 2.930 -0.619 -0.570 1.105 -0.352 -0.370 1.257 1.574 -0.155 0.036 1.649 2.679 -0.507 -0.334 age 0.639 -0.366 -0.423 1.615 1.731 -0.246 -0.157 1.974 2.964 -0.693 -0.758		48	-1.654	0.018	0.367	1.694								
1.105 -0.352 -0.370 1.257 1.574 -0.155 0.036 1.649 2.679 -0.507 -0.334 age 0.639 -0.366 -0.423 1.615 1.731 -0.246 -0.157 1.974 2.964 -0.693 -0.758	verage		0.787	-0.351	-0.412	1.383	1.860	-0.232	-0.078	2.008	2.930	-0.619	-0.570	3.071
0.639 -0.366 -0.423 1.615 1.731 -0.246 -0.157 1.974 2.964 -0.693 -0.758	Left Wing	Ę	1.105	-0.352	-0.370	1.257	1.574	-0.155	0.036	1.649	2.679	-0.507	-0.334	2.756
	Left Fuse	age	0.639	-0.366	-0.423	1.615	1.731	-0.246	-0.157	1.974	2.964	-0.693	-0.758	3.159

Appendix V

KC-135, Tail Number 64-14838 Painted Tinker AFB, May 97

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1 1 1 1 1 1 1 1 1 1																		
Column C				Fuselage(1)		Fuselage(4			Fuselage(1				elage(3)	Fuselage(4)	5			Fuselage(5)
Full trans				2/99	1/98	7/98	2/99	=	L		2/99	1/98	7/98	2/99	88			2/88
Column C				Test	test	test	Test	į	_	-	Test	test	test	Test	***			Test
Failure, AD Fail	lardness			SH.	끘	Ι	3H	2	_		픘	퐀	Η	HS	***			표
Fallure; AG	PATTI			697 psi	800 900	_	597 psi	700		L	192 psi	550 ps	⊢	995 psi	***			1393 psi
APP				15%	2	%	22	_	L	% 0	88	+	65%	***			88	
A	Ą						10 %	L	<u> </u>	8		20 %	10%					
CT Right Top Left Top Wing Tip Win	ATP								_	_								
CT See See See See See See See See See S	ဝ			35 %			85%	25	*	L	8 8			30 %	888			45 %
Right Top Left Top Wing Tip Wing Tip	CT			% 99	85 %			જ	L	-	5,8		20 %	2%				5%
Right Top Wing Tip Wing Tip	9				Ŀ	Pass		Ľ	ď	SS		•	Pass					
Right Top Wing Tip Test T																		
1/98 7/98 2/99 1/98 7/98 2/99 1/98 7/98 2/99 1/98 7/98 2/99 1/98 7/98 2/99 1/98 7/98 2/99 1/98 7/98 2/99 1/98 7/98 2/99 1/98 7/98 2/99 1/98 7/98 2/99 1/98 7/98 2/99 1/98 2/99		Right 1 Wing	t Top y Tip			Top Wing	 		Right	Top Wing			Top Wing selage)	Right Bottom Wing	r.	~	light Fuse	8
None None Lest None R- None R- None R- None R- None R- None None None R- None N		1/98	7/98	Π	1	_	Т	L.	L	L	Π	_	7/98	2/99) '	1/98	7/98	2/99
None		test	test	Test	test	test	Test	ā			Test	test	test	Test		test	ij	Test
1 Right Upper Wing (fuselage) 2 Right Upper Wing (fuselage) 3 Right Upper Wing (fuselage) 3 Right Upper Wing (fuselage) 3 Right Upper Wing (fuselage) 4 Right Upper Wing (fuselage) 5 Right Upper Wing (fuselage) 5 Right Upper Wing (fuselage) 5 Right Upper Wing (fuselage) 6 Right Upper Wing (fuselage) 6 1 8	9	None	None	9	None	\dashv	-8	ž	\dashv	2	8	None	None	4	Ц	None	None	8
1 Right Upper Wing (fuselage) 2 Right Upper Wing (fuselage) 2 Right Upper Wing (fuselage) 3 Right Upper Wing (fuselage) 3 Right Upper Wing (fuselage) 4 Right Upper Wing (fuselage) 2 Right Upper Wing (fuselage) 5 Right Upper Wing (fuselage) 7 Right Upper Wing (fuselage) <td></td> <td>,</td> <td></td>																	,	
AATTI Lost Lost Lest test Test <t< td=""><td></td><td>A Right C</td><td>Jpper Win</td><td>g (fuselage)</td><td></td><td></td><td></td><td>]</td><td>Right L</td><td>Upper Wing</td><td></td><td>*</td><td>Right Upper</td><td>Wing</td><td>2</td><td>Righ</td><td>nt Upper W</td><td>ng Tip</td></t<>		A Right C	Jpper Win	g (fuselage)]	Right L	Upper Wing		*	Right Upper	Wing	2	Righ	nt Upper W	ng Tip
Indeess Test				5/88			2/39				2/89	1/98	7/98	2/99		1/98	7/98	2/88
AATTI SH 3H 3H 3H 5H				-			Test				Test	test	test	Test	_	test	test	Test
AATTI AATTI 2239 psi 2239 psi 2239 psi 2239 psi 756 psi 756 psi 764 psi <t< td=""><td>ardness</td><td></td><td></td><td>돐</td><td></td><td></td><td>胀</td><td></td><td></td><td></td><td>돐</td><td></td><td>胀</td><td>Ŧ.</td><td></td><td>돐</td><td>돐</td><td>돐</td></t<>	ardness			돐			胀				돐		胀	Ŧ.		돐	돐	돐
Failure: AG AD 10% 40% 40% 40% 10%	PATTI			2239 psi			2289 psi			25	387 psi	2300 p.	щ	2338 psi		550 psi	784 psi	1940 psi
AP A	of Failure: AG			10%			40 %	***			15%	20 %	70%	25 %		10 %	10 %	10%
ATP	₽			% 0 6			% 09				85 %			75 %	L.,	% 06	88	% 06
CP	ATP														<u> </u>			
CT 55% 10% Pass	ပ္											25 %	H				10 %	
· Pass · Pass												55 %	Щ					
	8			•							•	•	Pass	•	<u> </u>	•	Pass	

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Pencil Hardness (Soft to Hard): 5b-4b-3b-2b-b-Hb-F-H-2H-3H-4H-5H-6H-7H-8H-9H (ASTM-D-3363)

Chalking: None - 8 - 6 - 4 - 2 (ASTM-D-4214)

AG = Adhesion of glue to stud or topcoat AP = Adhesion of Primer to substrate

ATP = Adhesion of Topcoat to Primer CP = Cohesion of Primer CT = Cohesion of Topcoat

Large Aircraft Coatings Flight Testing

APPENDIX VI

Painted Tinker AFB, May 98

		K	C-13	5, Tai	l No.	63-80	40 -		
Locatio	on	5/98 initial DFT mils	1/99 test DFT mils	5/98 initial 60 degree Gloss	1/99 test 60 degree Gloss	delta 60 degree Gloss	5/98 initial 85 degree Gloss	1/99 test 85 degree Gloss	delta 85 degree Gloss
Left Wing, Upper Surface	43 44 45 46 40 39 38 37 36 35	3.0 2.9 3.2 3.2 2.9 4.0 4.2 4.4 5.7 3.6	2.8 3.1 4.1 3.7 4.0 4.0	2.3 2.0 1.4 1.9 1.9 2.1 2.1 3.5 3.5	1.8 1.0 2.2 3.1 2.3 2.5	-0.1 -0.9 0.1 1.0 -1.2 -1.0	2.3 2.6 2.3 2.5 2.0 1.4 1.4 3.9 3.9 3.6	1.7 1.3 2.2 7.3 8.5 2.4	-0.3 -0.1 0.8 3.4 4.6 -1.2
LH Motors	49 50	16.7 19.0	4.0	1.8 1.5	2.0		3.0 2.4		
Left Fuselage	42 41	4.1 3.0		2.0 2.4			1.3 2.2		
Right Wing, Upper Surface	3 4 5 6 7 8 9 10 11 AP* AP* AP*	2.9 2.4 2.9 2.2 1.9 2.3 2.7 3.3 3.0 3.0		1.5 1.9 2.4 2.1 1.7 2.1 2.0 1.7 2.1 2.1 11.0 11.0 8.2			0.8 1.9 1.9 2.3 3.6 1.7 1.4 1.2 1.7 1.5 54.0 47.0		,
RH Motors	14 15	12.2 16.3		2.2 2.2			3.0 2.7		
Right Fuselage Average	AP* 12 13	5.4 6.2 4.1	3.6	9.5 2.5 2.5 2.5	2.2	-0.2	52.9 2.3 2.2 2.7	3.9	1.7

Deft MIL-P-23377G Primer Deft MIL-PRF-85285C Topcoat

AP* = Applique

Painted Tinker AFB, May 98

1791 psi 95 % Inboard #2 Engine None 1/99 test 2% 2H 5 Outboard #2 Engine 1592 psi 100 % None 1/99 test I KC-135, Tail Number 64-8040 4 1592 psi 100 % Inboard #1 Engine None 1/99 test ૠ ო 1194 psi None 10% **%** 06 1/99 test 里 Lift Point 1692 psi 40% None 25 % 35 % 1/99 test **2H** Wing Tip ATP Q AP 占 APC --(Left Side) Pencil Hardness Modified PATTI Failure Mode: Wet Tape Chalking

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Left Side - Deft APC

= ASTM D 659 Photographic Reference Standard

Pencil Hardness (Soft to Hard): 5b-4b-3b-2b-b-Hb-F-H-2H-3H-4H-5H-6H-7H-8H-9H

AG = Adhesion of glue to stud or topcoat AP = Adhesion of Primer to substrate ATP = Adhesion of Topcoat to Primer CP = Cohesion of Primer CT = Cohesion of Topcoat

Deft MIL-P-23377G Primer Deft MIL-PRF-85285C Topcoat

AP* = Applique

Appendix VI

Large Aircraft Coatings Flight Testing

APPENDIX VII

Notes from Mr. Sneed:

DEFT

- 1.) Worse than Courtauld's on flaps and in lesser exposed areas
- 2.) Peeling worse than on Courtauld's side
 - a.) Underside of wing
 - b.) Panel edges
 - c.) Leading edges (peeling/touchup)
 - d.) Around windshield (touched up)
- 3.) Appeared to be chalking
- 4.) Paint not sticking to sealant in a number of places

COURTAULDS

- 1.) Peeling
 - a.) Bad underside of wings
 - b.) Oklahoma Door
 - c.) Around Radome
 - d.) Bare metal around windshield
 - e.) Leading edge fastener row, upper wing, to bare metal -- fastener's showing
 - f.) Along sealant
- 2.) Touchup -- more rework
- 3.) Chalky appearance

SPRAYLAT

- 1.) Lot of rework near fuselage on upper wing
- 2.) More touchup around fasteners than rest of test aircraft
- 3.) Paint peeling/cracking along rivet rows and sealant
- 4.) Fuselage rework along fuselage seams
- 5.) Leading edge touchup and small amount of peeling to bare metal
- 6.) Touchup underside of wing
- 7.) Boom area under fuselage had primer showing
- 8.) Flight controls faded worse than Sherwin-Williams
- 9.) Peeling to bare metal around Radome
- 10.) Less peeling around windows than other Hickam paints

SHERWIN-WILLIAMS

- 1.) Rework over fasteners on upper wing
- 2.) Fuel staining along front fastener row (see 1. Above)
- 3.) Some touchup on upper wing
- 4.) Spot peeled to primer on upper wing

- 5.) Fuselage rework along fuselage seams
- 6.) Peeling/Cracking around and on panel rivets upper wing
- 7.) Visually better than Spraylat
- 8.) Formulated to Gunship luster
- 9.) Fasteners peeling to bare metal on Beaver Tail
- 10.) Rework spread over aircraft in general
- 11.) Leading edge touchup about the same as Spraylat side, maybe slightly more
- 12.) Cowling Leading edges peeling both to metal and primer
- 13.) Less fading and smoother surface than other aircraft

ADVANCED PERFORMANCE COATINGS (APC)

- 1.) Noticeable color difference between GSA Topcoat
 - a.) Depending on angle of sun, appears to be darker than Deft
 - b.) Smoothest paint to the touch
- 2.) Fasteners starting to corrode center of wing
- 3.) Chipped paint in one Spot
- 4.) Very little cracking around fasteners
- 5.) Test indicate Gunship luster. It appears to have a sheen

US PAINT

- 1.) Very little Radome leading edge peeling noted
- 2.) Possible touchup around pilots window
 - a.) Very hard to discern at close distance
 - b.) No peeling at time of inspection
- 3.) Typical nicks and peeling on and around doors and access panels
- 4.) Peeling to bare metal around 1 & 2 Engine cowling leading edges
 - a.) Nothing longer than 1-2 mm
 - b.) Looked better than some of the Hickam aircraft
- 5.) Very little RH wing leading edge peeling
 - a.) Two nicks to bare metal
- 6.) Number 3 engine cowling leading edge had no peeling
- 7.) Number 4 engine cowling leading edge had almost no peeling
- 8.) LH leading edge between number 1 and 2 engines had small amount of peeling
- 9.) LH leading edge outside of number 1 engine had some peeling
- 10.) No peeling evident on vertical and horizontal leading edges from ground view
- 11.) Sporadic touchup over aircraft fuselage
 - a.) Touchup appeared to be good match
 - b.) Low light in hanger, which may hide imperfections and chalking, makes it difficult to tell how well paint matched up
- 12.) All in all, the aircraft is in great shape for 22 months of service life
- 13.) Field units report aircraft looks better in direct sunlight than old Mil-C-85285 painted aircraft

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Large Aircraft Coatings Flight Testing

APPENDIX VIII

KC-135 Exterior Coating System Operational Test and Evaluation Test Plan August 1997

Prepared by:

Mike Spicer

Coatings Technology

Integration Office

Reviewed by: Maj Kevin Kuhn

Coatings Technology

Integration Office

Submitted by: OC-ALC/LAPEP, HQ AMC/LGBEF,

HQ ANG/LGMM

Approved by: KC-135 SPD

Further dissemination only as directed by OC-ALC/LCRA (August 1997) or higher DoD authority

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              3.2.2.1.2 MOP 2-1-2
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ABBREVIATIONS AND ACRONYMS

AFB Air Force Base

AMC Air Mobility Command

ANG Air National Guard

COI Critical Operational Issue
COTS Commercial Off The Shelf

CTIO Coatings Technology Integration Office

GSA Government Supply

HPACS High Performance Aerospace Coating System

HQ Head Quarters
MAJCOM MAJor COMmand

NCOIC Non Commissioned Officer In Charge

NESHAP National Emission Standards for Hazardous Air Pollutants

OC-ALC Oklahoma City-Air Logistics Center
PDM Programmed Depot Maintenance

OOT&E Qualification Operational Test and Evaluation

QPL Qualified Products List

SM-ALC SacraMento-Air Logistics Center

SPD Systems Program Director

T.O. Technical Order

UV UltraViolet

VOC Volatile Organic Compound

SECTION I INTRODUCTION

1.0 GENERAL. Oklahoma City Air Logistics Command (OC-ALC) in conjunction with Air Mobility Command (AMC) and Air National Guard (ANG) will conduct a Qualification Operational Test and Evaluation (QOT&E) of 1998 National Emission Standards for Hazardous Air Pollutants (NESHAP) compliant coating systems in the KC-135 operational environment using a current MIL-SPEC qualified coating system as a control and select the best performing coating system to be utilized on the KC-135 fleet.

1.1 SYSTEM INFORMATION

1.1.1 Background. The current TT-P-2756 coating system used on the exterior moldline of the KC-135 aircraft is not meeting performance requirements over the full Programmed Depot Maintenance (PDM) cycle. The KC-135 Systems Program Director (SPD) has directed that TT-P-2756 type material will no longer be used on KC-135 aircraft that have gone through depot and are stripped to bare metal. TT-P-2756 is a 1998 NESHAP compliant coating and as a result of this directive the depots(OC-ALC and SM-ALC) are faced with using non-NESHAP compliant coating systems until a NESHAP compliant coating system is tested, qualified and approved. The laboratory test and evaluation phase for an improved NESHAP compliant coating system was accomplished via the "High Performance Aerospace Coating System" (HPACS) contractual program

managed by WL/MLSS. Four promising coating systems were identified by the HPACS program as being worthy for flight test consideration.

1.1.2 Description All coating systems being tested are commercial off the shelf(COTS) products that meet 1998 NESHAP requirements. A "coating system", as referred to in this plan, is a primer and a topcoat combination. All primers being tested are a high-solids epoxy chromated primer with a VOC rating of 340 g/L or less. All topcoats being tested are a high-solids polyurethane topcoat with a VOC rating of 420 g/L or less.

The coating systems evaluated in this QOT&E are listed in the table below.

Manufacturer	Primer	Topcoat	Aircraft @ Station
US Paint	S9800-K13	Awlgrip	KC-135 @ Macdill AFB, Tampa Bay Fl.
Courtaulds	513X423C/930K118/ 530K015	832G062/930G052 UV Improved*	KC-135 @ Hickham AFB, Oahu Ha.
Deft	Mil-C-23377G TI CC 02Y40	Mil-C-85285B T1 03GY321**	Same Aircraft
Pratt & Lambert Sherwin-Williams	724-500/724-501 E90G203/V93V230	785-637/785-000/ 785-118 F93A26/V93V26/V93V1	KC-135 @ Hickham AFB, Oahu Ha.
Spraylat	EEAE-154 A/B	EUBG167 A/B	Same Aircraft

^{*} Courtaulds has added UV absorbers to their previous version topcoat to give better performance.

The test coating systems are expected to provide increased performance over the TT-P-2756 in the areas of weatherability, adhesion to the substrate, cleanability, and protection against corrosion.

1.2 OPERATIONAL ENVIRONMENT

- 1.2.1 Threat Summary Not applicable for this project
- 1.2.2 Operational Concept The coating systems are being tested as a drop-in replacement of TT-P-2756 for use on the outer moldlines of KC-135 aircraft. Therefore, part of this QOT&E is to check the compatibility with surface preparation materials and processes as well as spray equipment being utilized at the ALCs and field units. No major equipment changes are expected but, minor process changes could be realized

To ensure the performance of the coating systems is realized, severely corrosive, high UV, marine environments were selected as operational test sites. Also, this QOT&E project requires the normal KC-135 operating environment for testing. Special ranges, test facilities, and equipment are not required.

1.2.3 Maintenance Concept Normal touch-up and repair of the coating systems on the test aircraft by the field units will be the same procedure as for non-test aircraft, i.e. in

^{**} In May 96 Deft reformulated their MIL-C-85285 topcoat to give better performance.

accordance with T.O. 1-1-8, except appropriate test coating materials will be used. Adequate quantities of test coatings will be provided when the aircraft is delivered from the ALC and upon owning unit request. Evaluation forms will be provided to the selected POC.

Some destructive testing will be performed by the engineering team when conducting a local assessment of the test coating systems. The engineering team will be responsible for repairing the destroyed coating system. The method for repair is as follows: feather the edges of the area under repair by hand sanding with 150 grit sand paper, apply a Mil-P-23377G T1 CC primer or a Mil-P-85582 T1 C2 primer using a SEMPEN applicator, allow the coating to cure 2 hours, apply a Mil-C-85285B T1 topcoat in color 36173 using a SEMPEN applicator. The SEMPEN applicator and materials in side are products of Courtaulds Aerospace. The materials in the SEMPENS are Mil Spec qualified and have been incorporated into T.O. 1-1-8.

1.2.4 Training Concept The coating system selected from this QOT&E project for use on the KC-135 fleet will undergo a battery of tests by CTIO. The tests are designed to characterize the use of the coating system under different temperatures, humidities, and spray equipment. CTIO will take the results of the tests and working with the coating system manufacturer create a users guide for that particular coating system. The users guide will define the operating window for which the coating system can be used. Suggestions and consequences for using the coating system outside of the window will also be incorporated in the users guide. The users guide can be used by painters at the ALCs and field units as a starting point for setting up their spray equipment based on their given situation. Any problems that can not be solved with the use of the users guide can be directed to CTIO.

1.3 PROGRAM STRUCTURE At the point in time when a coating system(s) is selected for utilization on the KC-135 fleet, CTIO will work with GSA in setting up a vehicle for the procurement of the coating system(s). Performance data, characterizing the coating system(s), obtained from the HPACS program will be used to create a Purchase Description or Specification with a qualified products list (QPL). Quality assurance testing of the material for successive batches will be tested by CTIO and stated in the Purchase Description or Specification.

SECTION II QOT&E OUTLINE

2.0 OBJECTIVE AND CRITICAL OPERATIONAL ISSUES

The objective of this QOT&E is to conduct a flight test of NESHAP compliant coating systems with a Mil Spec coating system as a control and evaluate the performance characteristics of all coating systems per the COIs mentioned. The best performing coating system will be utilized on the KC-135 fleet.

The following COIs are derived from the Mission Need Statement, CAF/AMC/AETC/AFSOC/AFMC 812-97 (DRAFT).

Current Mil Spec coating systems(Mil-P-23377G CC, Mil-P-85285) provide adequate corrosion protection. Therefore, the test coating systems must provide equal or improved performance in the area of protection against corrosion compared to the current Mil-Spec coating system.

COI-1: Do the test coating systems provide equal or improved protection against corrosion compared with the control coating system.

The majority of the scuff sand and overcoat, and touch-up and repair activities performed at field units are a result of poor weathering and appearance characteristics of the Mil Spec coating systems. As a result, the test coating systems will have to show an improvement over the current Mil Spec coating system (Mil-P-23377G CC, Mil-P-85285).

COI-2: Do the test coating systems provide improved performance in the area of apperance.

COI-3: Do the test coating systems provide improved appearance characteristics over the control coating system.

2.1 SCOPE AND TEST CONCEPT HQ AMC is the lead organization in identifying aircraft for this QOT&E project. The three test aircraft identified are one AMC KC-135 tail number 64-14838 stationed at MacDill AFB and two ANG KC-135s, tail numbers 64-14832 and 59-1472, stationed at Hickam AFB.

The AMC KC-135 will go through PDM at OC-ALC and will be coated with a test coating system from U.S. Paint (primer S9800/K8032; topcoat Awlgrip H.S. Polyurethane) on 12 May 97.

The two ANG KC-135s will go through PDM at SM-ALC in the August/September 1997 timeframe. Tail number 64-14832 will be coated with a coating system from Courtaulds (primer 513X423C/930K118/530K015; topcoat 832G062/930G052) on the righthand side and a coating system from Deft (primer 02Y40; topcoat 03GY321) utilized as the control on the lefthand side of the aircraft. Tail number 59-1472 will be coated with a coating system from Spraylat (primer EEAE-154A; topcoat EUBG167 A/B) on the righthand side and the Pratt & Lambert (Sherwin-Williams) (primer E90G203/V93V230, topcoat F93A26/V93V26/V93V1) on the lefthand side of the aircraft.

Deft was selected as the control because of its extensive use on other weapon systems. An Application Data Sheet will be supplied to the ALC applying the coating systems and shall be completed at the time the coating systems are applied. Appendix A is a copy of the Application Data Sheet form.

Each aircraft will be evaluated after every wash cycle by the unit POC. Appendix B is a copy of the evaluation form that should be used by that field level person and sent to AMC/LGBEF, OC-ALC/LAPEP and CTIO upon completion.

On six month intervals an engineering team will conduct a local assessment of the coating systems in conjunction with local corrosion control and crew chief personnel. The engineering team will consist of engineers from the KC-135 SPD, corrosion control monitors of the participating MAJCOMs, and engineers from WL/MLSS-CTIO.

Appendix C is a copy of the evaluation form the engineering team will use to gather data to provide input to the Interim Test Event Report.

A decision point has been established 18 months from when the last KC-135 aircraft will be coated. At that point a decision between OC-ALC/LCR, OC-ALC/LAP, HQ AMC/LGM and HQ ANG/LG will be made as to the best performing coating but, the test coatings will be left on the aircraft a full PDM cycle for further evaluation.

2.2 PLANNING CONSIDERATIONS AND LIMITATIONS

2.2.1 Planning Considerations The ideal flight test procedure for coating systems is to apply the test coating system on one side of the test aircraft and apply the control coating system on the other side of the same test aircraft. The reasons for this paint scheme is stated in a letter issued March 1996 to all MAJCOM Corrosion Managers and authored by Gary Stevenson on behalf of WL/MLSS.

Do to circumstances out of our control, aircraft tail number 64-14838 and possibly aircraft tail number 59-1472 will not receive this paint scheme. Steps are being taken in order to ensure meaningful data will be collected from the two test aircraft.

Aircraft, tail number 64-14838 which will coated with the US Paint coating system will be stationed at MacDill AFB.

Aircraft, tail number 59-1472 which will be coated with the Spraylat coating system on one side and the Pratt & Lambert (Sherwin-Williams) coating system on the other side will be stationed at Hickham AFB. The other test aircraft, tail number 64-14832 that has the Deft coating system on one side of the aircraft will be used as the control coating system for comparing data collected from aircraft tail number 59-1472.

The variables associated with the work arounds will be noted in the reports.

- 2.2.1.1 Aircraft Availability The test aircraft are regularly scheduled for routine depot maintenance and will be operating in a severely corrosive, high UV marine environment. It is desired that test aircraft shall not be retired or transferred to another environment for the period of testing (a full PDM cycle).
- 2.2.1.2 Operational Support The respective MAJCOMs shall brief their operational field units about the QOT&E plan and their expected duties. The operational field units shall complete the evaluation forms provided, use the appropriate test coatings supplied for touch-up and repair when needed, and give the same attention to the test aircraft as would be given to any normal operating aircraft. No more, no less. A complete scuff sand and overcoat shall not be performed on the test aircraft without approval from the appropriate MAJCOM representative.
- 2.2.1.3 Equipment, Materials, and Processes All aspects in applying the test coatings shall be in accordance with T.O. 1-1-8 and T.O. 1-1-691.
- 2.2.2 Estimated Cost All coating systems will be purchased by AFMC TTO/TTP through WL/MLSS and delivered to the appropriate ALC. One gallon kit of the coating systems will accompany the respective test aircraft for touch-up and repair purposes. The ALCs will absorb any additional costs involved with the application of the test and

control coatings. In the unlikely event that catastrophic failure should occur, the appropriate MAJCOM will provide funding for the removal of test materials and the refinishing of the aircraft. Each organization participating in the evaluation of the coating systems is responsible for their TDY funding to the test site. Costs associated with test plan development, Interim and final reports, and their distribution will be absorbed by WL/MLSS-CTIO.

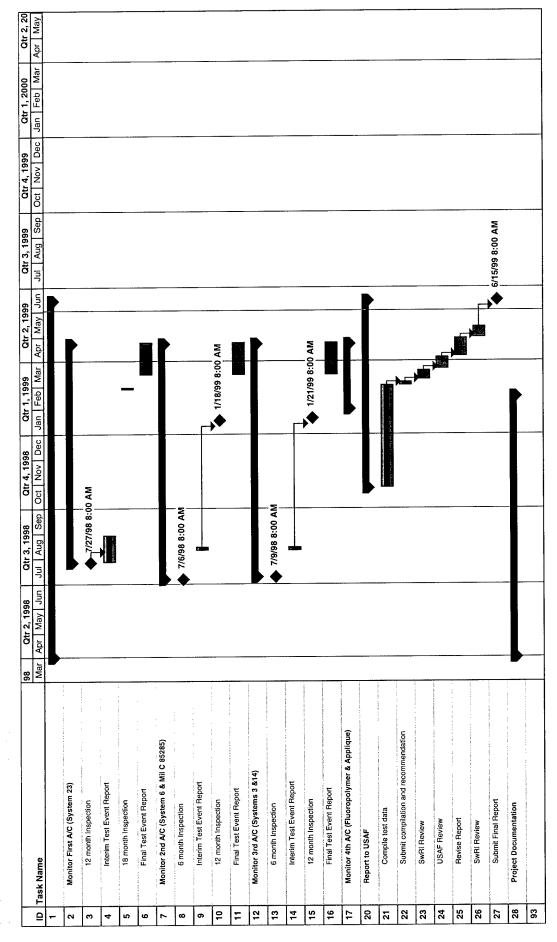
2.3 QOT&E SCHEDULE AND READINESS REQUIREMENTS

Ref. page 11

SCHEDULE GOES HERE

LARGE AIRCRAFT COATING SYSTEM ZHTV98WL23 - ZHTV99CT88





Jun 99 CEVV PMR

100	MOE	MOP
		IMOP3-1-3: Use of a portable gloss meter of 85 degree geometry in
		saccoldance with Asim 1922 shall show less change in gloss on the resistate as compared to the control side.
	TOTAL PROPERTY AND THE	MOP 3-1-4; Paint chips from the test coating and control coating shall be
		collected and analyzed in the laboratory to determine physical and chemical property changes
		MOP 3-2-1: Use of a portable colorimeter in accordance with ASTM
	MOE 3-2: The color stability of the test coating systems shall be	D2244 shall show a delta E ratio of test coating system to control coating
	an improvement over the currently used coating systems.	system of less than 1.0 (i.e. delta E of test coating / delta E of control
		MOP 3-2-2: Use of a black velvet cloth in accordance with ASTM ????
		Shall not show evidence of chalking
		Mor 3-2-3. Fairth of the laboratory to determine physical and
		chemical property changes.
A AMPLIANA, MAJAMANAMA AN MEN YANG YANG YANG YANG YANG YANG YANG YAN	TOTAL DAY OF WHITE A PROPERTY AND	MOP 3-3-1: Use of a portable gloss meter of 60 degree geometry in
	MOE 3-3: The gloss stability of the test coating systems shall be	accordance with ASTM D523 shall show less change in gloss on the test
	an improvement over the currently used coating systems.	side as compared to the control side.
		MOP 3-3-2: Use of a portable gloss meter of 85 degree geometry in
		accordance with ASTM D523 shall show less change in gloss on the test
		side as compared to the control side.
		MOP 3-3-3. Paint chips from the test coating and control coating shall be
		collected and analyzed in the laboratory to determine physical and
		chemical property changes.
	MOE 3-4: The fluid resistance stability of the test coating systems	MOE 3-4: The fluid resistance stability of the test coating systems IMOP 3-4-1: Using the pencil hardness technique in accordance with
	shall be an improvement over the currently used coating	FTMS-141, the change in hardness of the test coating shall be less than
	systems.	the change in hardness on the control coating.
		MOP 3-4-2: Upon visual inspection the degree of adhesion on the test
	TOTAL	side shall be equal to or better than the control side for all interfaces
		MOP 3-4-3. Use of a portable colorimeter in accordance with ASTM
		D2244 shall show a delta E ratio of test coating system to control coating
		system of less than 1.0 (i.e. delta E of test coating / delta E of control
	_	MOP 3-4-4: Paint chips from the test coating and control coating shall be
		collected and analyzed in the laboratory to determine physical and
COMPANY OF THE PROPERTY OF THE	MOE 3-5: The touch-up/repaired area shall show an	MOP 3-5-1: Use of a portable colorimeter in accordance with ASTM
	improvment relative to color and gloss over the currently used	D2244 shall show a delta E ratio of test coating system to control coating
		system of less than 1.0 (i.e. delta E of test coating / delta E of control
		MOP 3-5-2: Use of a portable gloss meter of 60 degree geometry in
		accordance with ASTM D523 shall show less change in gloss on the test
		side as compared to the control side.
		MOP 3-5-3: Use of a portable gloss meter of 85 degree geometry in
		accordance with ASTM D523 shall show less change in gloss on the test
		side as compared to the control side.
		MOP 3-5-4: Paint chips from the test coating and control coating shall be
		collected and analyzed in the laboratory to determine physical and
		cnemical property changes,

I C	MOE	dCM
5	N.C.	
COI-1: Do the test coating systems provide equal or improved protection against corrosion compared with the	MOE 1-1: The corrosion protection of the test coating systems shall be equal to or show an improvement over the currently	MOP 1-1-1: Upon visual inspection the fest coafed skins shall show no more exfoliation corrosion around fastener countersinks and panel
control coating system?		edges than on the control coated skins.
		MOP 1-1-2: Upon visual inspection the test coated skins shall show no more fillform corrosion than on the control coated skins.
	MOE 1-2: The degree of compatibility (adhesion) of primer with	MOP 1-2-1: Upon visual inspection the degree of adhesion on the test
	the substrate and topcoat with the primer.	side shall be equal to or better than the control side for all interfaces
		MOR 1-2-2, Modified Agresion Pain resimply bet Astivitory stain measure a minimum of 1000 psi.
A CAMPAGN TO THE TOTAL CONTRACT OF THE TOTAL	MOE 1-3: The integrity of the test coating system on and around	
	upper and lower wing skin fasteners shall be equal or show an improvement over the currently used conting system.	stated in this test plan the test coating shall score an equal or higher value than the control coating
		MOP 1-3-2: Paint chips from the point of failure for the test coating or
		control coating shall be collected and analyzed in the laboratory to
		determine physical and chemical property changes.
		MOP 2-1-1: Use of a portable gloss meter of 60 degree geometry in
COI-2: Do the test coating systems provide equal or	MOE 2-1: The gloss stability of the fest coating systems shall be	decordance with ASIM D323 shall show less change in gloss on the test
		MOP 2-1-2: Use of a portable gloss meter of 85 degree geometry in
		accordance with ASTM D523 shall show less change in gloss on the test
		side as compared to the control side.
		MOP 2-1-3: Paint chips from the test coating and control coating shall be
		collected and analyzed in the laboratory to defermine priystall and
		MOP 2.2-1-1 lsa of a 45 degree // degree reflectometer in accordance
	MOE 2-2: The cleanability of the test coating systems shall be an	MOE 2-2: The cleanability of the test coating systems shall be an with ASTM D523 shall show an increase of at least 5 percentage points
	improvment over the currently used coating systems.	over the control side.
		MOP 2-2-2: Use of a portable gloss meter of 60 degree geometry in
		accordance with ASTM D523 shall show less change in gloss on the test
		side as compared to the control side.
		MOP 2-2-3: Use of a portable gloss meter of 85 degree geometry in
		accordance with ASIM U323 shall show less change in gloss on the Test
		MOD 2.2.4. Daint chins from the test coating and control coating shall be
		WOR 2-2-4. Failin Chips from the less counting and control counting shall be collected and analyzed in the laboratory to determine physical and
	MOE 2-3. The fluid resistance stability of the test coating systems	
	shall be an improvement over the currently used coating	FTMS-141, the change in hardness of the test coating shall be less than
	sysiems.	MOB 2.3.9. How visual inspection the degree of adhesion on the fest
		side shall be equal to or better than the control side for all interfaces
		MOP2-3-3: Use of a portable colorimeter in accordance with ASTM
		D2244 shall show a delta E ratio of test coating system to control coating
		system of less than 1.0 (i.e. delta E of test coating / delta E of control
		MOP 2-3-4: Paint chips from the test coating and control coating shall be
		collected and analyzed in the laboratory to determine physical and
COI-3: Do the test coating systems provide equal or		MOP 3-1-11 like of a 45 dearnee/0 dearnee reflectometer in accordance
color. Do the less counting systems provide equal or improved appearance characteristics over the control continue wetens.	MOE 3-1: The cleanability of the test coating systems shall be an improvement over the currently used coating systems	
		MOP 3-1-7: The of a portable aloss meter of 60 degree agametry in
		accordance with ASTM D523 stall show less change in gloss on the test
		side as compared to the control side.

SECTION III METHODOLOGY

3.0 GENERAL

- 3.0.1 COI and MOE/MOP Matrix Ref. page 12-13
- 3.1 COI-1: Do the test coating systems provide equal or improved protection against corrosion compared with the control coating system?
- 3.1.1 Scope In order to ensure the test coating systems show corrosion protection characteristics, the test coating systems shall be flight tested on test aircraft stationed in a severely corrosive, high UV marine environment for a minimum of 20 months. The test coating systems shall show equal or improved performance as compared to the Mil Spec qualified Deft coating system in order to pass this COI. The Deft coating system will be used as the control coating system.
- 3.1.2 Measures of Effectiveness/Performance and Evaluation Criteria
- 3.1.2.1 MOE 1-1 The corrosion protection of the test coating system shall be equal to or show an improvement over the currently used coating systems
- 3.1.2.1.1 MOP 1-1-1 Upon visual inspection, the test coated skins shall show no more exfoliation corrosion around fastener countersinks and panel edges than on the control coated skins.
- 3.1.2.1.2 MOP 1-1-2 Upon visual inspection, the test coated skins shall show no more filliform corrosion than on the control side for all interfaces.
- 3.1.2.2 MOE 1-2 The degree of compatibility (adhesion) of primer with the substrate and topcoat with the primer.
- 3.1.2.2.1 MOP 1-2-1 Upon visual inspection, the degree of adhesion on the test side shall be equal to or an improvement to the control side for all interfaces.
- 3.1.2.2.2 MOP 1-2-2 Using the Modified Adhesion testing per ASTM 5179, the test and control coating systems shall measure a minimum of 1000 psi. This test shall be performed on two areas of the test aircraft per coating system. The first area is the upper section of the fuselage just past the wing root. The second area is the lower section of the fuselage just past the wing root. This is a destructive test method for the coating system in the localized area. Repair of the coating system is referenced in section 1.2.3 Maintenance Concept, second paragraph.
- **3.1.2.3 MOE 1-3** The integrity of the test coating system on and around upper and lower wing skin fasteners shall be equal or show improvement over the currently used coating system.

3.1.2.3.1 MOP 1-3-1 Upon visual inspection and using the evaluation criteria stated, the test coating system shall score an equal or higher value than the control coating system based on the criteria below.

No evidense of cracking or adhesion loss	4
Cracked circumferential in counter sink	3
Cracked and 1/4 moon adhesion loss around counter sink and fastener	2
Cracked and 1/2 moon adhesion loss around counter sink and fastener	1
Cracked and full moon adhesion loss around counter sink and fastener	0

3.2 COI-2: Do the test coating systems provide improved performance in the area of visible detection?

- 3.2.1 Scope Per Mil-C-85285B the specular gloss of camouflage topcoats at 60 degrees angle of incidence shall have a reading of 5 or less. Mil-C-85285B topcoats have not been able to maintain the 5 or less reading over time and after many wash cycles. The test coating systems shall show improved performance in maintaining camouflage gloss measured at 60 degrees and 85 degrees over the control coating system in order to pass this COI.
- 3.2.2 Measures of Effectiveness/Performance and Evaluation Criteria
- 3.2.2.1 MOE 2-1 The gloss stability of the test coating system shall be an improvement over the currently used coating systems.
- 3.2.2.1.1 MOP 2-1-1 Use of a portable gloss meter of 60 degree geometry in accordance with ASTM D523 shall show less change in gloss on the test side as compared to the control side.

At the time when the test and control coating systems have been applied, a gloss reading shall be recorded for each coating system. On 6 month intervals, the gloss reading shall be recorded for each coating system. The delta of the test coating system shall be less than the delta of the control coating system in order to pass.

3.2.2.1.2 MOP 2-1-2 Use of a portable gloss meter of 85 degree geometry in accordance with ASTM D523 shall show less change in gloss on the test side as compared to the control side.

At the time when the test and control coating systems have been applied, a gloss reading shall be recorded for each coating system. On 6 month intervals, the gloss reading shall be recorded for each coating system. The delta of the test coating system shall be less than the delta of the control coating system in order to pass.

- 3.2.2.1.3 MOP 2-1-3 Paint chips from the test and control coating systems shall be collected and analyzed in the laboratory to determine physical and chemical property changes.
- **3.2.2.2 MOE 2-2** The cleanability of the test coating systems shall be an improvement over the currently used coating systems.

- 3.2.2.2.1 MOP 2-2-1 Use of a 45 degree/0 degree reflectometer in accordance with ASTM D523 shall show an increase of at least 5 percentage points over the control side.
- 3.2.2.2.2 MOP 2-2-2 Same as MOP 2-1-1
- 3.2.2.2.3 MOP 2-2-3 Same as MOP 2-1-2
- 3.2.2.2.4 MOP 2-2-4 Same as MOP 2-1-3
- **3.2.2.3 MOE 2-3** The fluid resistance stability of the test coating system shall be an improvement over the currently used coating systems.
- 3.2.2.3.1 MOP 2-3-1 Using the pencil hardness technique in accordance with FTMS-141, the change in hardness of the test coating shall be less than the change in hardness on the control coating.
- 3.2.2.3.2 MOP 2-3-3 Same as MOP 1-2-1
- 3.2.2.3.3 MOP 2-3-4 Same as MOP 2-1-3
- 3.3 COI-3: Do the test coating systems provide improved appearance characteristics over the control coating system?
- 3.3.1 Scope Appearance characteristics is comprised of cleanability of the coating system, color and gloss stability of the coating system over time and after touch-up and repair, and lastly fluid resistance of the coating system. The test coating systems shall show improved performance in these areas over the control coating system in order to pass this COI.
- 3.3.2 Measures of Effectiveness/Performance and Evaluation Criteria
- 3.3.2.1 MOE 3-1 The cleanability of the test coating systems shall be an improvement over the currently used coating systems.
- 3.3.2.1.1 MOP 3-1-1 Same as MOP 2-2-1
- 3.3.2.1.2 MOP 3-1-2 Same as MOP 2-1-1
- 3.3.2.1.3 MOP 3-1-3 Same as MOP 2-1-2
- 3.3.2.1.4 MOP 3-1-4 Same as MOP 2-1-3
- **3.3.2.2 MOE 3-2** The color stability of the test coating systems shall be an improvement over the currently used coating systems.
- 3.3.2.2.1 MOP 3-2-1 Same as MOP 2-3-3

- 3.3.2.2.2 MOP 3-2-2 Use of a black velvet cloth in accordance with ASTM ??? shall not show evidence of chalking.
- 3.3.2.2.3 MOP 3-2-3 Same as MOP 2-1-3
- **3.3.2.3 MOE 3-3** The gloss stability of the test coating systems shall be an improvement over the currently used coating systems.
- 3.3.2.3.1 MOP 3-3-1 Same as MOP 2-1-1
- 3.3.2.3.2 MOP 3-3-2 Same as MOP 2-1-2
- 3.3.2.3.3 MOP 3-3-3 Same as MOP 2-1-3
- **3.3.2.4 MOE 3-4** The fluid resistance stability of the test coating systems shall be an improvement over the currently used coating systems.
- 3.3.2.4.1 MOP 3-4-1 Same as MOP 2-3-1
- 3.3.2.4.2 MOP 3-4-2 Same as MOP 1-2-1
- 3.3.2.4.3 MOP 3-4-3 Same as MOP 2-3-3
- 3.3.2.4.4 MOP 3-4-4 Same as MOP 2-1-3
- 3.3.2.5 MOE 3-5 The touch-up/repaired area shall show an improvement relative to color and gloss over the currently used coating systems.
- 3.3.2.5.1 MOP 3-5-1 Same as MOP 2-3-3
- 3.3.2.5.2 MOP 3-5-2 Same as MOP 2-1-1
- 3.3.2.5.3 MOP 3-5-3 Same as MOP 2-1-2
- 3.3.2.5.4 MOP 3-5-4 Same as MOP 2-1-3

SECTION IV ADMINISTRATION

4.0 TEST MANAGEMENT

4.1 TASKING

Coatings Technology Integration Office (CTIO) shall:

- 1.) Develop a Test Plan for conduct of QOT&E
- 2.) Fund and coordinate delivery of test coating systems to ALCs

- 3.) Lead the engineering team in performing tests and collecting data on the test aircraft on the six month technical evaluation of the test coating systems.
- 4.) Draft and coordinate the Interim Test Reports 30 days after the six month technical evaluations.

OC/ALC shall:

- 1.) Appoint a Test Manager/Director (Donna Ballard, OC/ALC/LAPEP, (405)736-5986)
- 2.) Apply US Paint test coating system on KC-135 aircraft, tail number 64-14838
- 3.) Coordinate with SM-ALC the application of remaining test coating systems on KC-135 aircraft, tail numbers 64-14832 and 59-1472.

SM/ALC shall:

- 1.) Apply Deft control coating system and Courtaulds test coating system on KC-135 aircraft, tail number 64-14832.
- 2.) Apply Pratt & Lambert (Sherwin-Williams) test coating system and Spraylat test coating system on KC-135 aircraft, tail number 59-1472

HQ AMC/LGBEF shall:

- 1.) Coordinate use of one KC-135 aircraft, tail number 64-14838
- 2.) Coordinate with HQ ANG/LGMM the providing of two KC-135 aircraft, tail numbers 64-14832 and 59-1472
- 3.) Coordinate with the field unit at MacDill AFB on responsibilities
- 4.) Coordinate with the field unit at Hickam AFB on responsibilities

HQ ANG/LGMM shall:

1.) Provide two KC-135 aircraft, tail numbers 64-14832 and 59-1472

6th MXS/LGMF, MacDill AFB shall:

- 1.) Complete "Post Wash Evaluation Form" and send to CTIO.
- 2.) Coordinate with local bio environmental engineering office for the use of the test coating systems.

POC: Jerry Chaplin 6th MXS/LGMF

7607 Hanger Loop Drive MacDill AFB, FL. 33621

DSN 968-7436

154 MXS/LGMF, Hickham AFB shall:

- 1.) Complete "Post Wash Evaluation From" and send to CTIO.
- 2.) Coordinate with local bio environmental engineering office for the use of the test coating systems.

POC: Gary Cera

MSG/E-7

154 MXS/LGMF

360 Harbor Drive, Bldg. 1055 Hickham AFB, Hi. 96853-5517 DSN

4.2 TRAINING REQUIREMENTS.

Coating system manufacturers will be present to monitor the application process and instruct maintenance personnel on the application procedures.

4.3 SAFETY and ENVIRONMENTAL IMPACT

All equipment and coating systems used in this test plan meet 1998 NESHAP requirements.

Material Safety Data Sheet (MSDS) for the test and control coating systems will be provided along with the materials to the using organizations.

4.4 SECURITY All aspects of this QOT&E project is **UNCLASSIFIED**; however, technical papers and reports generated from this project will comply with distribution statement B stated in AFI 61-204.

SECTION V REPORTING

5.0 REPORTS

- 5.0.1 Inspection Sheets: Post Wash Evaluation Sheets will be accomplished by MacDill AFB and Hickam AFB after each wash cycle and sent to the HQ AMC/LGBEF, OC-ALC/LAPEP, and CTIO.
- 5.0.2 Interim Test Event Report: Interim Test Event Report will be issued by CTIO 30 days after each technical evaluation. A technical evaluation will be performed by the technical engineering team on 6 month cycles starting from when the last test aircraft is coated.
- 5.0.3 Final Test Report: Final Test Report will be issued by CTIO 60 days after the completion of the project.

5.1 BRIEFINGS

Status briefings will be given to the CTSC on a quarterly basis by the CTIO.

AEROSPACE COATING SERVICE TEST APPLICATION DATA SHEET

Depaint Method Used: (Include Manu. and Product ID of Chemicals, Dwell Times, e Describe pre-treatment steps of aircraft after depaint and prior to prime:(Include Man and Product ID of Chemicals, Mix Ratios, Dwell Times, etc.)	
Describe pre-treatment steps of aircraft after depaint and prior to prime:(Include Man and Product ID of Chemicals, Mix Ratios, Dwell Times, etc.)	
Describe pre-treatment steps of aircraft after depaint and prior to prime:(Include Man and Product ID of Chemicals, Mix Ratios, Dwell Times, etc.)	
	 nu.

Describe problems experienced with pre-treatment, if any:	
	

AEROSPACE COATING SERVICE TEST APPLICATION DATA SHEET

Batch Number:	
Was Primer Allowed to Achie	ve Spray Booth Temp Prior to Mixing: YES NO
Mixing Time:	(min) Viscosity:
Time After Mixing before Spr	aying Begins:(min)
How Long to Spray this Batch	:(min)
Temperature:	Humidity:
Other Comments:	
Topcoat	
Manufacturer Name/Product N	Number:
Batch Number:	
Was Topcoat Allowed to Achi	eve Spray Booth Temp Prior to Mixing: YES NO
Mixing Time:	(min) Viscosity:
Time After Mixing before Spra	aying Begins:(min)
	:(min)
How Long to Spray this Batch	
	Humidity:

AEROSPACE COATING SERVICE TEST APPLICATION DATA SHEET

Type Paint Guns (HVLP, Electrosta	auc, etc.):			
Manufacturer/Model of Paint Guns	•			_
Number of Tip and Aircap:				_
Size/Type Paint Gun Heads:			· · · · · · · · · · · · · · · · · · ·	
Inside Dimensions of Hoses: Air_		Fluid		_
Hose Length: Air	Flui	d <u>:</u>		
Pressure Pots YES NO	Plural Mix	YES NO		
Auto Stirring in Cups/Pots YES	NO			
Shop Air Pressure: (PSI)		(CFM)	•	
Air Pressure (at Gun):		Nozzle:		
Water/Oil Separator Installed:	YES	no 🗆		
•				

AEROSPACE COATING SERVICE TEST CURE TIMES DATA SHEET

Appearance of Primer:	Tack-free Time	• · · · · · · · · · · · · · · · · · · ·		_ Hours
Dry Film Thickness:Mils Appearance of Primer: Topcoat Tack-free Time:Hours Cure Time Before Flight:Hours During Cure – TemperatureHumidity Wet Tape Test: Dry Film Thickness:Mils	Cure Time Before Overcoating:			_Hours
	During Cure – Temperature	Humidity		·
Topcoat Tack-free Time:Hours Cure Time Before Flight:Hours During Cure – TemperatureHumidity Wet Tape Test:Mils	Dry Film Thickness:		Mils	
Tack-free Time:Hours Cure Time Before Flight:Hours During Cure – TemperatureHumidity Wet Tape Test: Dry Film Thickness:Mils	Appearance of Primer:			
Cure Time Before Flight:Hours During Cure – TemperatureHumidity Wet Tape Test: Dry Film Thickness:Mils	Topcoat			
During Cure – Temperature Humidity Wet Tape Test: Dry Film Thickness: Mils	Tack-free Time:			_Hours
Wet Tape Test:Mils	Cure Time Before Flight:			Hours
Dry Film Thickness:Mils	During Cure – Temperature	Humidity		-
•	Wet Tape Test:			
Appearance of Topcoat:	Dry Film Thickness:		_Mils	
	Appearance of Topcoat:			·

POST WASH INSPECTION SHEET

					Gen	eral	Infor	matio	on				
Today's Date							Air	Aircraft Type					
Inspector							Tai	Tail No.					
Parked in: Hange	r 📗 c	or on I	light	Line			Tot	Total Flight Hours					
					Coat	ing	Infor	matic	on				
Painted by					catio							Date	
Surface Preparati	on												
Primer				Man	ufact	turer	•			В	Batch No.		
Topcoat			Manufacturer					В	atch	No.			
		Ex			ondi	tior	ns this	Rep	ortin	ıg Pe	riod		
Avg. Ground Temp.			>80°				0° -80° F.			<50°	F. [
Avg. Ground Humid	ity			% RH	<u> </u>		% - 80	% RH		<509			
Avg. Ground Light			Outs				anger [ng singens	Mixe	d L		
							al Exp		е				
Chemica	Туре			Degra	ating adatic erved	on	Comm	ents					
	Yes	No	Ι,	Yes	No								
Hydraulic													
Fuel													
De-Icing Fluid													
Engine Oil													
		7. Jako 1			Air	rera	ıft - V	/ach		14.89.70	la K		
Area Washed		<u>.</u>	er er er	Da			sh Chem			Type,	Mfg.	, Product No., Name, Mix	
Exterior													
Hot Water Used: Yes	П и	о 🗌											
Other (Exhaust Track Port, etc)	s, APU	Track,	Gun				 				- 11 - 1		

POST WASH INSPECTION SHEET

	N	laintenanc	e - Touch-U	o Paintir	ıg		
Area Touched-Up	Date	Primer: Mil S	•	Applicat	tion	Reason for Repair	
741. 11 C		Topcoat: Mil S	Spec /Mfg.	Method			
Wing, Upper Surface			. •			•	
Wing, Lower Surface							
Wing, Leading Edge							
Fuselage, Top							
Fuselage, Sides		***************************************					
Fuselage, Bottom							
Empennage							
Stabs, Vertical							
Stabs, Horizontal							
		Vis	ual Inspectio	n	排造		
Area			Defect			Cause	Size
							(sq. in.)
Wing, Right, Upper Su	ırface		Chip □Stain □ □Chalk □Softe			uid ir FlowImpact	uris - 1
		Other				nknown	
Wing, Right, Lower St	urface		Chip Stain			uid	
		Blister L Other	Chalk Softe			ir Flow Impact	
Wing, Right, Leading	Edge		Chip Stain			uid	
		Blister [_Chalk _Softe			ir Flow Impact	
	· ·	Other		7D 1		nknown uid	
Wing, Left, Upper Sur	тасе	☐None ☐ ☐Blister ☐	Chip Stain Chalk Softe	Peel		ir Flow Impact	
		Other				nknown	
Wing, Left, Lower Sur	face		Chip Stain	Peel		uid	
		Blister Other	Chalk Softe	n	=	ir Flow Impact	
Wing, Left, Leading E	dge		Chip Stain	Peel		uid	
<i>5,6</i>	J	Blister	Chalk Softe		□A	ir Flow Impact	
		Other				nknown	20 0.0
Fuselage, Right, Upper	r Surface		Chip]Peel		uid ir Flow	
		Other				nknown	

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AEROSPACE COATING SERVICE TEST POST WASH INSPECTION SHEET

Fuselage, Right, Lower Surface	None Chip Stain Peel Blister Chalk Soften Other	Fluid Air Flow Impact Unknown
Fuselage, Left, Upper Surface	None Chip Stain Peel Blister Chalk Soften Other	Fluid Air Flow Impact Unknown
Fuselage, Left, Lower Surface	None Chip Stain Peel Blister Chalk Soften Other_	Fluid Air Flow Impact Unknown
Empennage	None Chip Stain Peel Blister Chalk Soften Other	Fluid Air Flow Impact Unknown
Stabilizer, Vertical, Right Side		Fluid Air Flow Impact Unknown
Stabilizer, Vertical, Left Side	None Chip Stain Peel Blister Chalk Soften Other	Fluid Impact Unknown
Stabilizer, Right Horizontal, Upper Surface	None Chip Stain Peel Blister Chalk Soften Other	Fluid Air Flow Impact Unknown
Stabilizer, Right Horizontal, Lower Surface	None Chip Stain Peel Blister Chalk Soften Other	Fluid Air Flow Impact Unknown
Stabilizer, Left Horizontal, Upper Surface	None Chip Stain Peel Blister Chalk Soften Other	☐Fluid ☐Air Flow ☐Impact ☐Unknown
Stabilizer, Left Horizontal, Lower Surface	None Chip Stain Peel Blister Chalk Soften Other	☐Fluid ☐Air Flow ☐Impact ☐Unknown
#1 Engine Cowling/Intake	None Chip Stain Peel Blister Chalk Soften Other	☐Fluid ☐Impact ☐Unknown
#2 Engine Cowling/Intake	None Chip Stain Peel Blister Chalk Soften Other	Fluid Impact Unknown
#3 Engine Cowling/Intake	None Chip Stain Peel Blister Chalk Soften Other	☐Fluid ☐Air Flow ☐Impact ☐Unknown
#4 Engine Cowling/Intake	None Chip Stain Peel Blister Chalk Soften Other	Fluid Impact Unknown

AEROSPACE COATING SERVICE TEST POST WASH INSPECTION SHEET

Overall Comments				
		•		
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				·
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				·

TECHNICAL EVALUATION TEAM INSPECTION SHEET

	Gen	eral Inf	ormat	ion			
Today's Date			Aircraft Type				
Inspector			Serial No.				
Title of Inspector			No. of Flight Hours				
Date of Last Inspection							
	Co	ating Inf	ormatio	n			
Painted by	Locati	on	Date				
Surface Preparation							
Primer	Manufacturer				Batch	No.	
Topcoat	Manufacturer			Batch No.			
	Ex	posure C	onditio	าร			
Avg. Ground Temp.	>80° F.	50° -80°			<50° F.		
Avg. Ground Humidity	> 80% RH	50 % - 8			<50% RH		
Avg. Ground Light	Outside	Hanger			Mixed 🗌		
	v	sual Ins	mectio	n			
Area/Tests	Location / Subst		p.c.c.c	Def	ect	Size (sq. in.)	
Wing, Right - Upper Surface				Eros			
wing, Right - Opper Surface		NO STEP FWD (4 typ)			ping		
					ering		
					ing		
		//		lking			
		/ [Stair				
					osion		
					er(Specify)		
	1 /0 /	77				60 2	
		1/					
	10 7						
	/		<u>w</u>				
Wing, Right - Lower Surface				Eros	sion		
		7		Chi	oping		
		\prec			tering		
	Black	//		Peel			
	Stripe	//			lking		
		1 D			ns .		
		-		rosion			
	Black	Black			Other(Specify)		
	Stripe	V = V	.			<u>(</u>	
		\rightarrow \backslash	.\	1 2 3 3 1 1 27 7 1			
			//			6	
		\	$\setminus \gamma \mid$	ATMAN			
	1		<u> </u>	in the St		de la companya de la	

TECHNICAL EVALUATION TEAM INSPECTION SHEET

Area	Location / Substrate	Defect	Size (sq. in.)
Wing, Left - Upper Surface		Erosion	
, mg, zon opperounter		Chipping	
	1/2	Blistering	_
]	1 / 1/	Peeling	
	1 /2 41	Chalking	
	The state of the s	Stains	
	Ta	Corrosion	
1	17 4	Other(Specify)	
	/a H/		
	To I		
	NO STEP 1		
	NO STEP FWD (4 typ)		
Wing, Left - Lower Surface		Erosion	
i		Chipping	
		Blistering	
i	Black Stripe	Peeling	
		Chalking	
		Stains	
1	Black Seripe	Corrosion	
		Other(Specify)	
	241ibe \		
	/ //		·
	1 / 4		
Fuselage, Forward Section		Erosion	
<i>C</i> ,		Chipping	
		Blistering	
		Peeling	
		Chalking	
		Stains	
		Corrosion	
	Ton Winne	Other(Specify)	
	Top View		
	1		
			•
	Bottom View		

AEROSPACE COATING SERVICE TEST TECHNICAL EVALUATION TEAM INSPECTION SHEET

Location / Substrate	Defect	Size (sq. in.)
	Chipping	
	Blistering	
	Peeling	
	Chalking	
•	Stains	
	Corrosion	
	<u>)</u>	
	Erosion Chipping Blistering	
	Chalking	
	Stains	
	Corrosion	
	Other(Specify)	<u> </u>
	00	Erosion Chipping Blistering Peeling Chalking Stains Corrosion Other(Specify) Erosion Chipping Blistering Peeling

AEROSPACE COATING SERVICE TEST TECHNICAL EVALUATION TEAM INSPECTION SHEET

Area	Location / Substrate	Defect	Size (sq. in.)
Fuselage, Left Side		Erosion	
		Chipping	
		Blistering	
		Peeling	
		Chalking	
	,	Stains	
		Corrosion	
		Other(Specify)	· .
Angle of Attack Probe	Jet Fuel S Fast Acting O Light	Door	
Fuselage, Right Side		Erosion	
ruselage, Right Side		Chipping	
		Blistering	
	·	Peeling	
		Chalking	
		Stains	
		Corrosion	
		Other(Specify)	
	Stars and Bars Findow	0	Angle of Attack Probe
	00		0

TECHNICAL EVALUATION TEAM INSPECTION SHEET

Area	Location / Substrate	Defect	Size (sq. in.)
Stabilizer, Vertical Right Side		Erosion	
		Chipping	
		Blistering	
		Peeling	
		Chalking	
		Stains	
		Corrosion	
		Other(Specify)	
		Other(Speedry)	
-			
Stabilizer, Vertical, Left Side			
Stabilizer, vertical, Left Side		Erosion	
		Chipping	
		Blistering	
	/ <i>[</i> 7]	Peeling	
	/ / / /	Chalking	
		Stains	
	/ / /	Corrosion	
	/ /	Other(Specify)	
Stabilizer, Horizontal, Right	·	Erosion	
Top Surface		Chipping	
		Blistering	
**:		Peeling	
		Chalking	
:		Stains	
		Corrosion	
		Other(Specify)	
			* **
•			
Stabilizer Horizontal Dight		Procing	
Stabilizer, Horizontal, Right Bottom Surface		Erosion	
DOROIII SUITACC	1111	Chipping	
	\ \\ \\ \\	Blistering	
	\ \ \ \	Peeling	
•	 	Chalking	
		Stains	
		Corrosion	
	\ \\	Other(Specify)	
	\ \ \		
	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \		
	\ \\	·	

TECHNICAL EVALUATION TEAM INSPECTION SHEET

Area	Location / Substrate	Defect	Size (sq. in.)
Stabilizer, Horizontal, Left		Erosion	
Top Surface		Chipping	
		Blistering	-
		Peeling	
		Chalking	
		Stains	
		Corrosion	
		Other(Specify)	
·	\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\		·
Stabilizer, Horizontal, Left		Erosion	
Bottom Surface		Chipping	
	\\\\\\\	Blistering	
	/ / // -	Peeling	
		Chalking	
:	\ \ \	Stains	
		Corrosion	
		Other(Specify)	
			,

POST WASH INSPECTION SHEET

damen of a second			gelt (brown)	(Gene	ral	Info	cm	ation				
Today's Date					Air	Aircraft Type							
Inspector							Tai	Tail No.					
Parked in: Hange	er o	r on F	light I	Line			То	tal	Flight	t Ho	ours		
				(ാat	ing	Info	rm	ation				1000000 Ref. 1000000000000000000000000000000000000
Painted by		<u>ad palaki ka</u>	<u>15 41 (56.5 4-</u>	·	cation		- 14 14 14 14 14 14 14 14 14 14 14 14 14		And the second	2019 2 44	T 7833-86 (40 Table 174	Date	
Surface Preparati	on											<u> </u>	
Primer		,]	Man	ufact	urer	r				Batch	No.	
Topcoat		-]	Man	ufacti	urer	ŗ				Batch	No.	
		Exp	osur	e Co	ondi				Repor	tin			
Avg. Ground Temp.			>80° F	·. 🗌		50	0° -80° F	F. [<50⁰ F. [
Avg. Ground Humid	lity		> 80%				0 % - 80		RH []	<50% RH		
Avg. Ground Light			Outsid				langer				Mixed _]	
				-111	Cher	nic	al Ex	рc	sure				in and and
Chemica				Degra Obse	ating adatio erved	on l	Comn	ner	nts				
	Yes	No	_ Y	es .	No			_					
Hydraulic													
Fuel													
De-Icing Fluid													
Engine Oil													
		\$250			Air	cr	aft - V	W	ash				15 27 E
Area Washed	:			Da			ash Che			pec,	Type, Mfg	., Product No., Name, Mix	
Exterior				T									
Hot Water Used: Ye		• <u> </u>					· · · · · · · · · · · · · · · · · · ·		,				
Other (Exhaust Trac Port, etc)	ks, APU	Track,	Gun										
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POST WASH INSPECTION SHEET

	N	Lainter	iance - To	uch-Up	Painti	ng		
Area Touched-Up	Date	Primer:	Mil Spec /Mfg		Applica	tion	Reason for Repair	
		Topcoat:	Mil Spec /Mfg	5•	Method	···········		
Wing, Upper Surface			- 5				-	
Wing, Lower Surface								
Wing, Leading Edge								
Fuselage, Top								
Fuselage, Sides								
Fuselage, Bottom								
Empennage		·					*** **********************************	
Stabs, Vertical								
Stabs, Horizontal								
			Visual Ins	pection				建
Area			Defe	ct			Cause	Size (sq. in.)
Wing, Right, Upper Su	rface	None	e Chip	Stain [Peel	F	luid	****
			er Chalk			ПА	ir Flow	
Wing, Right, Lower Su	rface		e Chip	Stain []	Peel		uid	
		☐Blist ☐Othe	er Chalk	Soften		Δ	ir Flow Impact	
Wing, Right, Leading E	Edge		e Chip			F	uid	
		☐Blist ☐Othe	er Chalk	Soften			ir Flow Impact nknown	
Wing, Left, Upper Surf	ace	None			Peel		uid	
		☐Blist☐Othe		Soften			ir Flow Impact nknown	
Wing, Left, Lower Surf	ace	None		Stain 🔲 I	Peel	=	uid	
	i	Blist Othe		Soften			ir Flow Impact nknown	
Wing, Left, Leading Ed	ge.	None		Stain F	Peel		uid	
g, Dott, Dottomb Da	.60	Blist		Soften		=	ir Flow Impact	
		Othe					nknown	
Fuselage, Right, Upper	Surface	None	Chip 🗌	StainF	Peel	FI	uid	
		Bliste		Soften			r Flow Impact	
		Othe	<u>r </u>				nknown	

POST WASH INSPECTION SHEET

Fuselage, Right, Lower Surface	None Chip Stain Peel Blister Chalk Soften Other	☐Fluid ☐Air Flow ☐Impact ☐Unknown
Fuselage, Left, Upper Surface	None Chip Stain Peel Blister Chalk Soften Other	☐Fluid ☐Air Flow ☐Impact ☐Unknown
Fuselage, Left, Lower Surface	None Chip Stain Peel Blister Chalk Soften Other	Fluid Air Flow Impact Unknown
Empennage	None Chip Stain Peel Blister Chalk Soften Other	Fluid Air Flow Impact Unknown
Stabilizer, Vertical, Right Side	None Chip Stain Peel Blister Chalk Soften Other	☐Fluid ☐Air Flow ☐Impact ☐Unknown
Stabilizer, Vertical, Left Side	None Chip Stain Peel Blister Chalk Soften Other	☐Fluid ☐Air Flow ☐Impact ☐Unknown
Stabilizer, Right Horizontal, Upper Surface	None Chip Stain Peel Blister Chalk Soften Other	☐Fluid ☐Air Flow ☐Impact ☐Unknown
Stabilizer, Right Horizontal, Lower Surface	None Chip Stain Peel Blister Chalk Soften Other	☐Fluid ☐Air Flow ☐Impact ☐Unknown
Stabilizer, Left Horizontal, Upper Surface	None Chip Stain Peel Blister Chalk Soften Other	☐Fluid ☐Air Flow ☐Impact ☐Unknown
Stabilizer, Left Horizontal, Lower Surface	None Chip Stain Peel Blister Chalk Soften Other	☐Fluid ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐
#1 Engine Cowling/Intake	None Chip Stain Peel Blister Chalk Soften Other	☐Fluid ☐Air Flow ☐Impact ☐Unknown
#2 Engine Cowling/Intake	None Chip Stain Peel Blister Chalk Soften Other	☐Fluid ☐Air Flow ☐Impact ☐Unknown
#3 Engine Cowling/Intake	None Chip Stain Peel Blister Chalk Soften Other	☐Fluid ☐Air Flow ☐Impact ☐Unknown
#4 Engine Cowling/Intake	None Chip Stain Peel Blister Chalk Soften Other	☐Fluid ☐Air Flow ☐Impact ☐Unknown

AEROSPACE COATING SERVICE TEST POST WASH INSPECTION SHEET

Overall Comments							
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